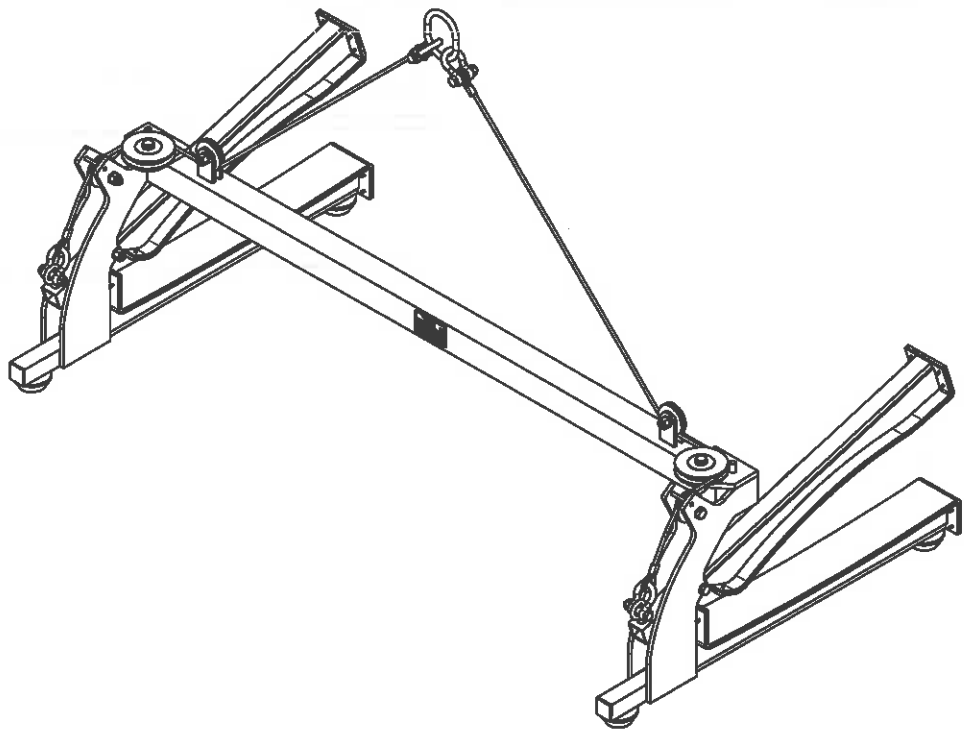
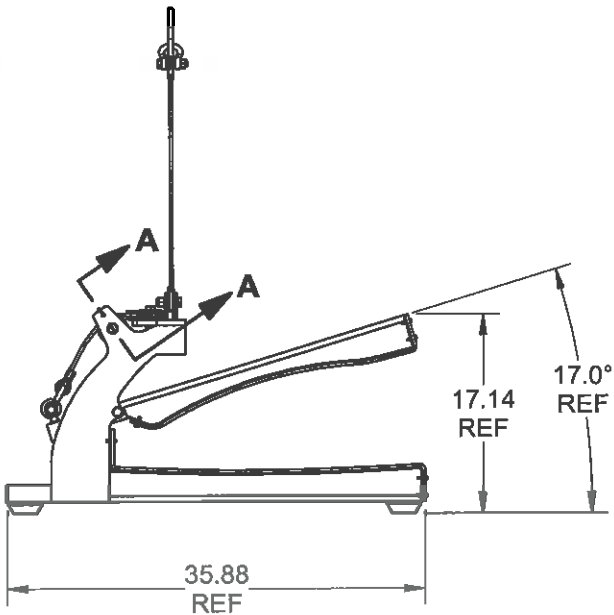


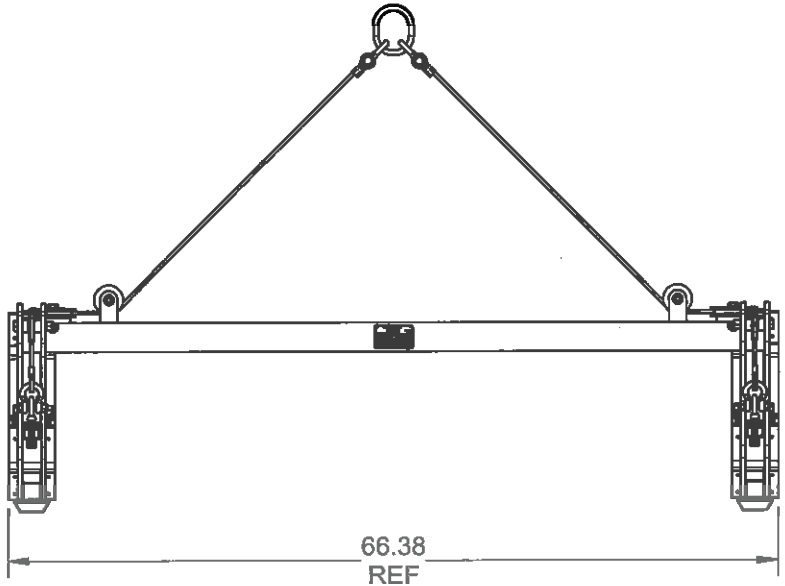
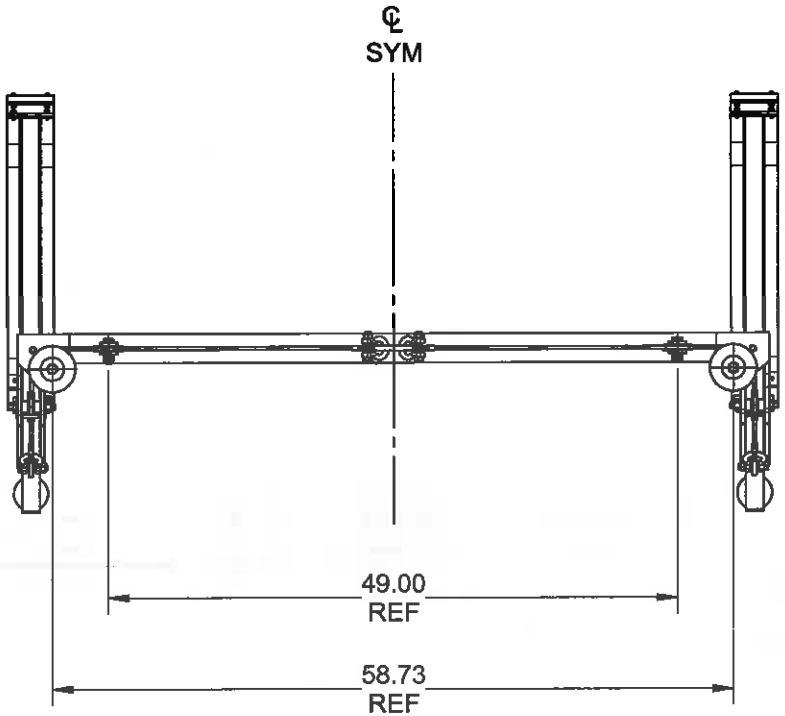
ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10321-041-M-1	CLAMP ASSEMBLY
-20	4	RB 92700-10321-041-M-20	PULLEY SPACER
25	1	RB41011	DART PLACARD
26	1	McMaster#3119T2 OR EQUIV.	STEEL OBLONG LINK 7/16" THK. X 3-1/2" INSIDE LG. X 2-9/16" INSIDE WIDTH.
27	2	McMaster#3550T34 OR EQUIV.	WIRE ROPE SLING 1/4" DIA. X 4' LG.
28	2	McMaster#3175T410 OR EQUIV.	STEEL PULLEY 4" OD. X 1/2" ID. X 13/16" THK. X 1200 LBS. CAPACITY
29	4	McMaster#3434T118 OR EQUIV.	STEEL PULLEY 2-1/2" OD. X 1/2" ID. X 1/2" THK. X 675 LBS. CAPACITY
30	4	McMaster#90081A077 OR EQUIV.	ZINC PLATED STEEL SCREW NAIL #2 SIZE X 1/4" LG.
31	6	McMaster#95615A220 OR EQUIV.	STEEL NYLON INSERT LOCKNUT 1/2"-20 X 19/32" HEIGHT
32	4	CARRLANE#CL-36521-FAS OR EQUIV.	FORGED STEEL ANCHOR SHACKLE 1/2" PIN DIA. X 3000 LBS. LOAD RATING
33	2	AN8-16A	BOLT
34	2	AN8-20A	BOLT
35	2	AN8-32A	BOLT
36	12	NAS1149F0863P	WASHER



**RB 92700-10321-041-M DUAL CLAMP M/R BLADE SLING**



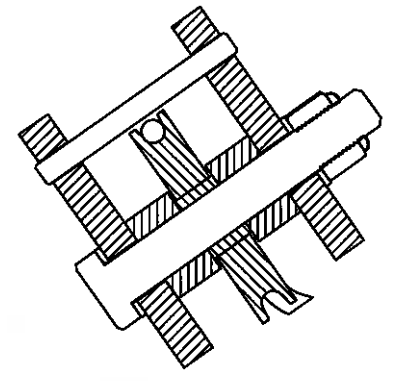
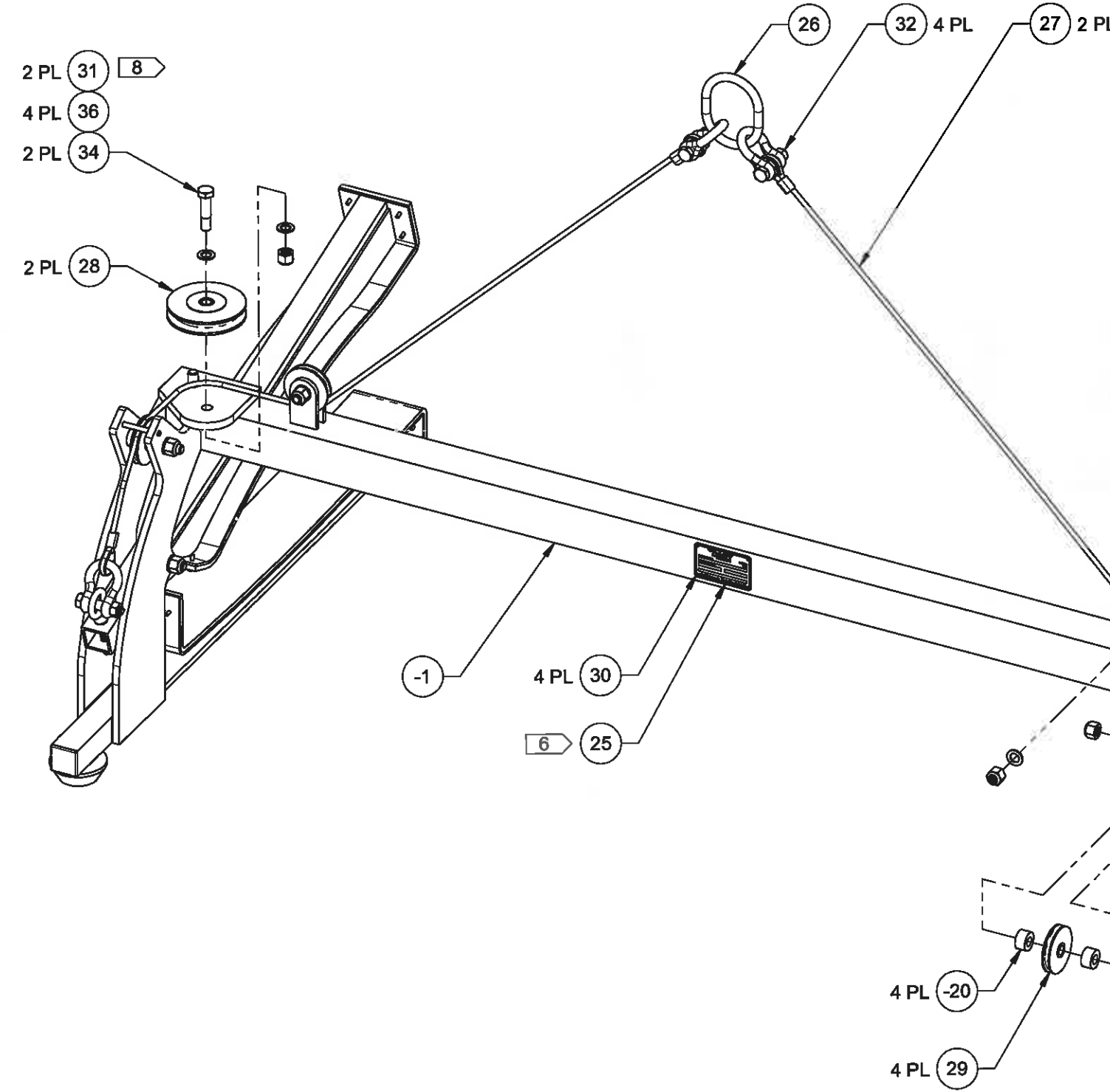
**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
VP



- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: ENGRAVE THE TOOL P/N, S/N AND "SWL: 440 LBS" ON THE DART PLACARD WHERE INDICATED
  - 7) ASSEMBLE AS SHOWN
  - 8) TORQUE ITEM 31 TO 40-58 FT-LBS (480-690 IN-LBS)

A1	NEW ISSUE		KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA TOOL PART # <b>RB 92700-10321-041-M</b> REV. A1 SHEET 1 OF 29 TITLE <b>DUAL CLAMP M/R BLADE SLING</b> SCALE NTS DATE <b>2/14/2019</b> COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	KPT		
CHECKED	KPT		
MFG. APPR.	DP		
APPROVED			

8 7 6 5 4 3 2 1



**SECTION A-A**  
2 PL

- 8
- 31 2 PL
- 36 4 PL
- 33 2 PL

- 2 PL 35
- 4 PL 36
- 2 PL 31 8

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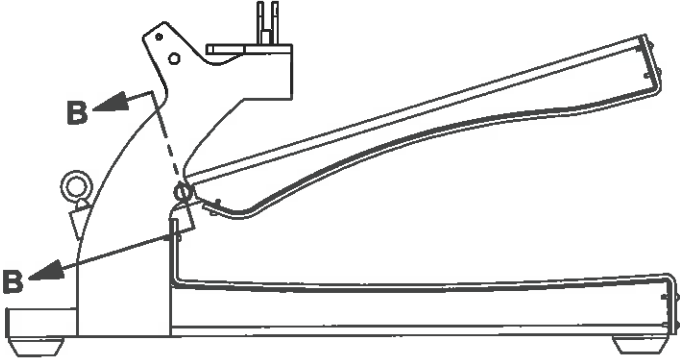
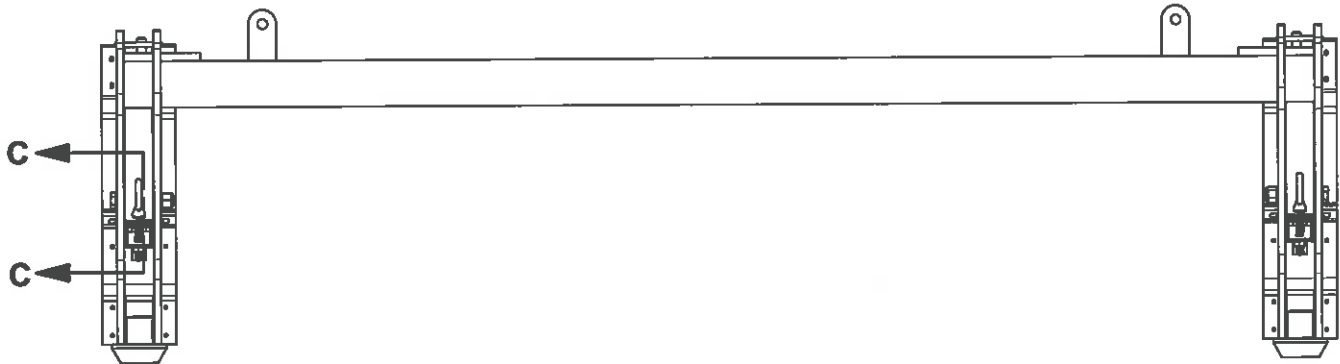
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DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 2 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-2	1	RB 92700-10321-041-M-2	FRAME WELDMENT
-13	2	RB 92700-10321-041-M-13	TOP CLAMP ASSEMBLY
-19	2	RB 92700-10321-041-M-19	BOTTOM CLAMP PROTECTION
-22	2	RB 92700-10321-041-M-22	TORSION SPRING BUSHING
-23	1	RB 92700-10321-041-M-23	RIGHT HAND TORSION SPRING
-24	1	RB 92700-10321-041-M-24	LEFT HAND TORSION SPRING
37	4	McMaster#9223K68 OR EQUIV.	POLYURETHANE ROUND BUMPER 3/8"-16 X 2-15/16" DIA. X 1-7/8" OAL HEIGHT
38	2	McMaster#9565K29 OR EQUIV.	PLASTIC PLUG 1-1/2" LG. X 1-1/2" WIDTH. X 1/2" HEIGHT
39	2	McMaster#95615A220 OR EQUIV.	STEEL NYLON INSERT LOCKNUT 1/2"-20 X 19/32" HEIGHT
40	12	McMaster#97519A042 OR EQUIV.	STEEL BLIND RIVETS 5/32" DIA. X 0.675" LG.
41	2	AN8-31A	BOLT
42	4	NAS1149F0863P	WASHER

PROTOTYPE  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
WFP



**RB 92700-10321-041-M-1 CLAMP ASSEMBLY**

NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) ASSEMBLE AS SHOWN  
8) APPLY 3M 1300L BETWEEN THE SURFACES OF ITEM -19 AND ITEM -2, AND REMOVE EXCESS  
9) TORQUE ITEM 39 TO 40-58 FT-LBS (480-690 IN-LBS)

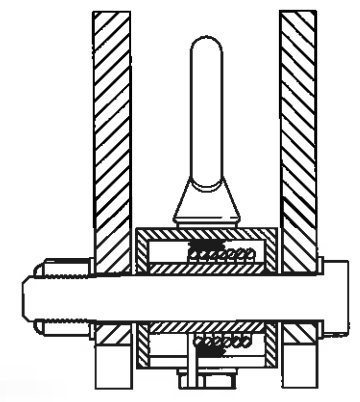
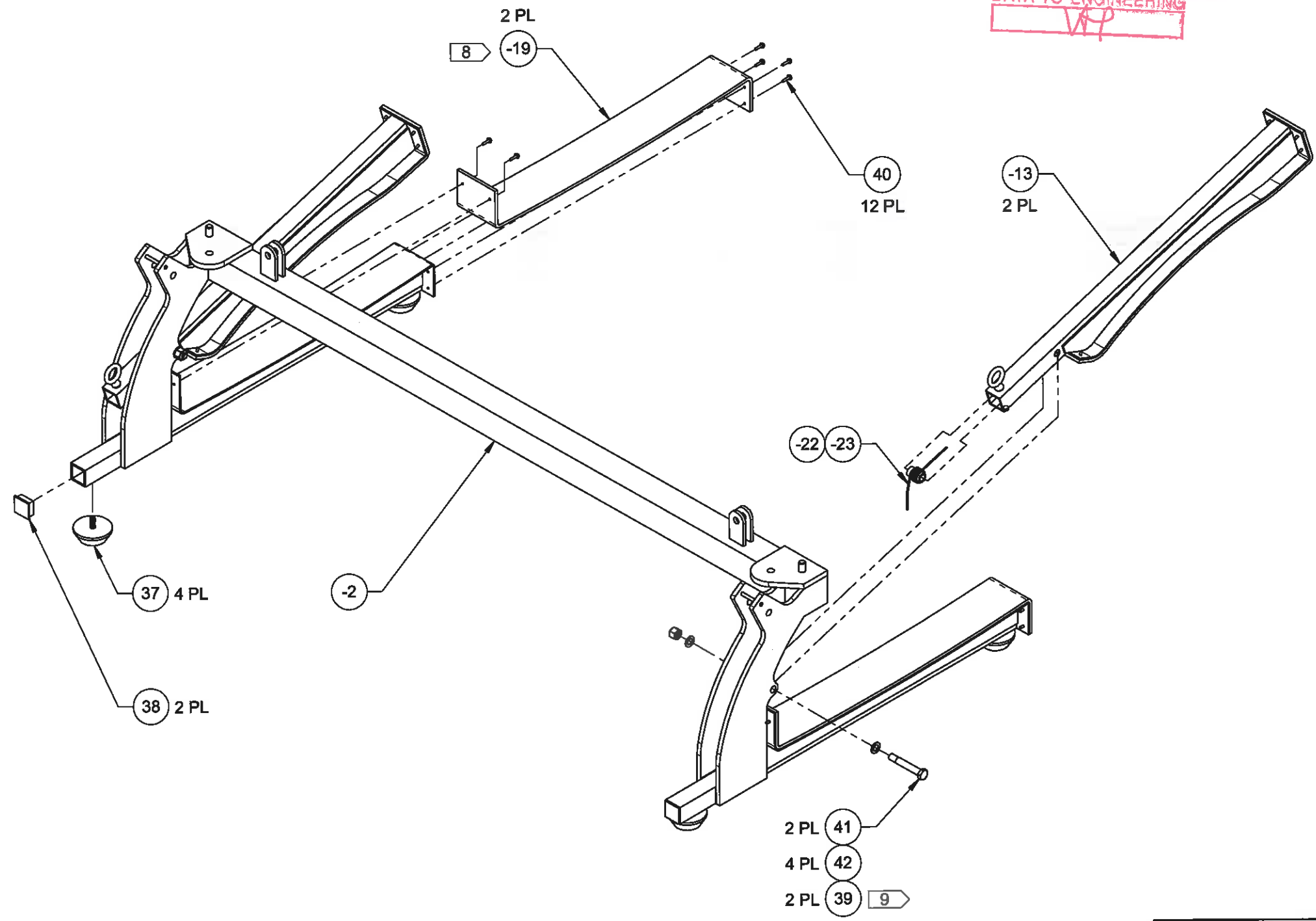
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 3 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
DATE 2/14/2019		COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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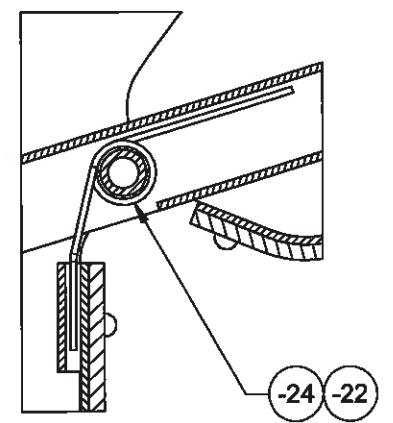
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**PROTOTYPE**  
PLEASE RETURN ALL ISSUE  
DATA TO ENGINEERING  
VP



**SECTION B-B**  
(ROTATED 17° CW)  
TYP

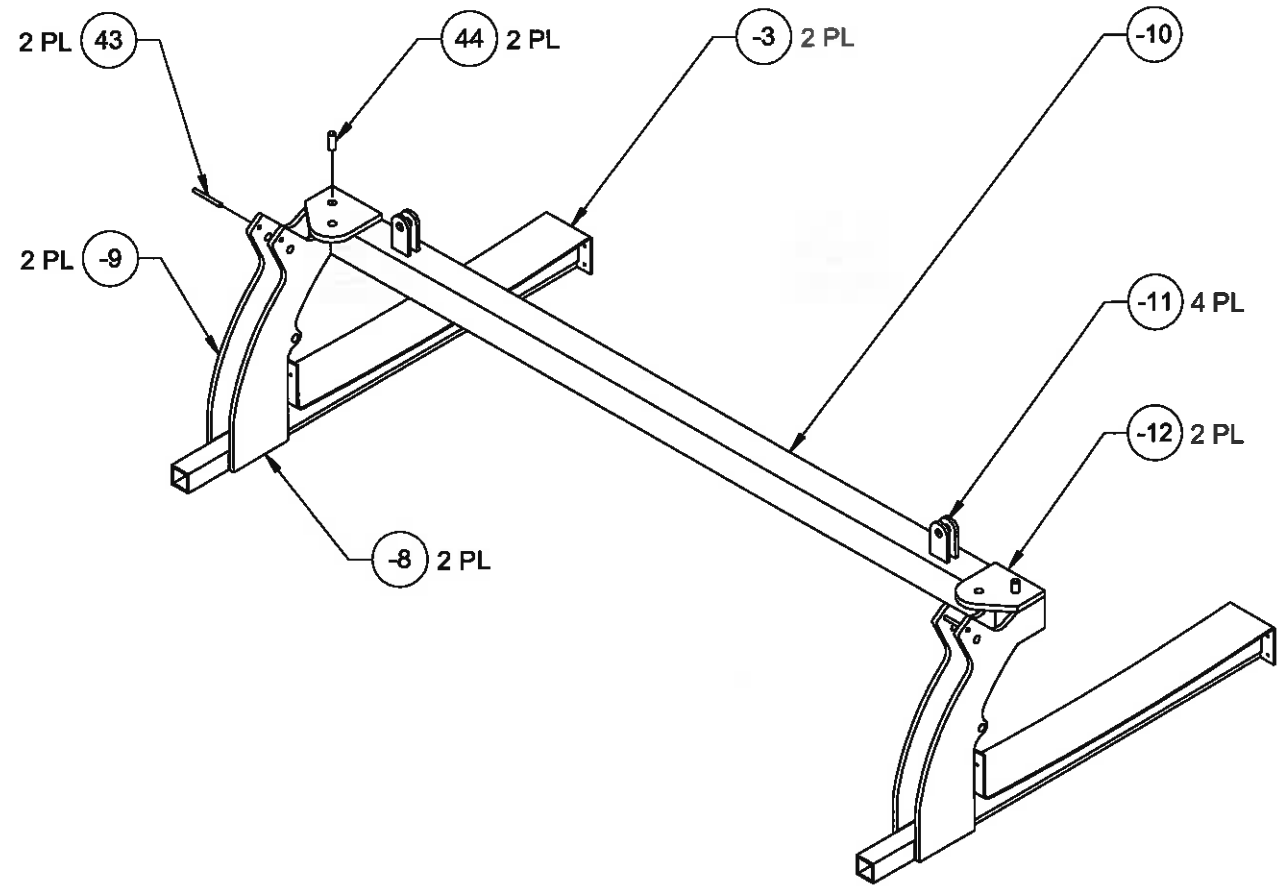
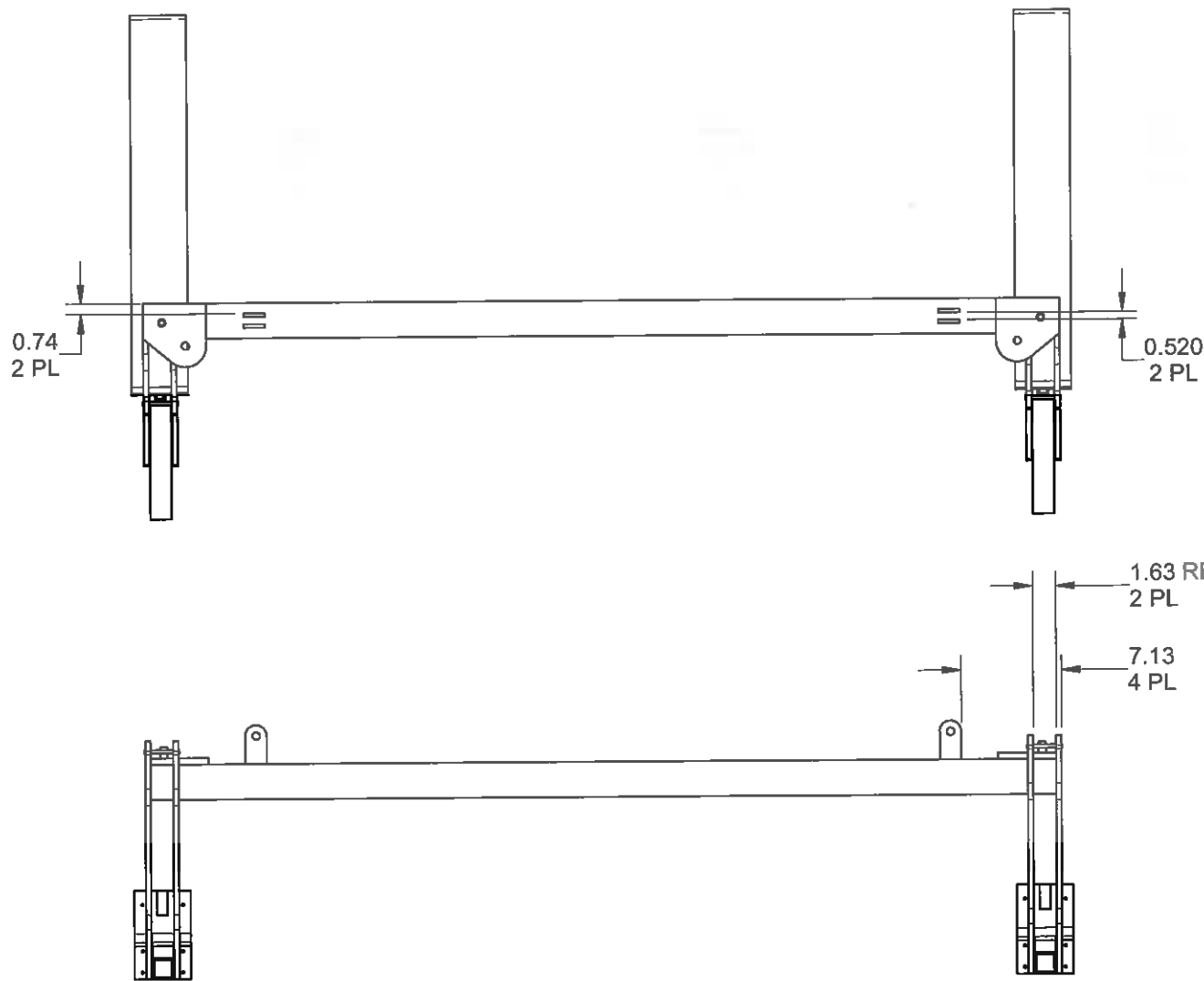


**SECTION C-C**  
TYP

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 4 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
DATE <b>2/14/2019</b>		<small>COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

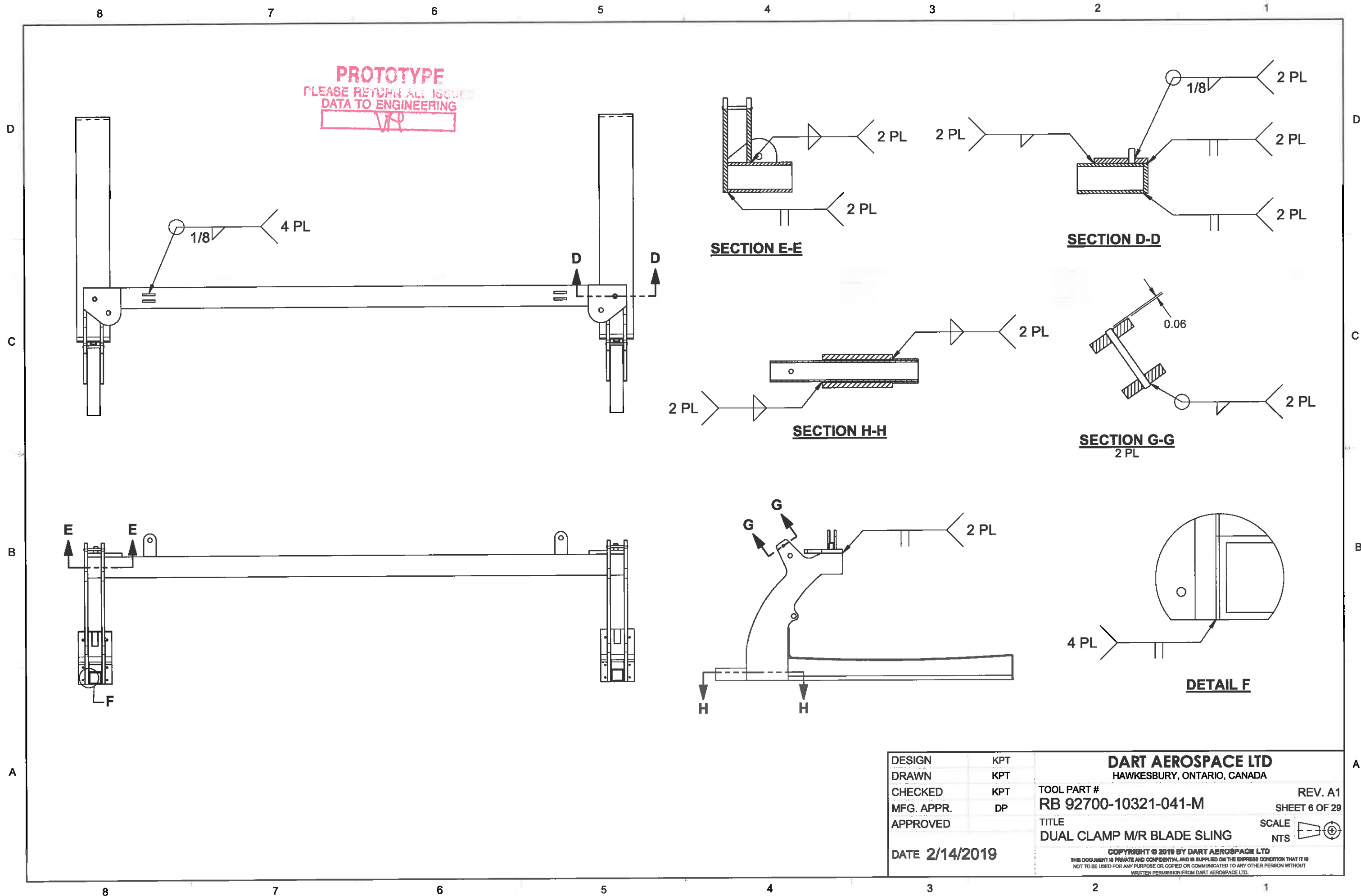
ITEM #	QTY	PART #	PART TITLE
-3	2	RB 92700-10321-041-M-3	BOTTOM CLAMP WELDMENT
-8	2	RB 92700-10321-041-M-8	INNER FRAME SUPPORT
-9	2	RB 92700-10321-041-M-9	OUTER FRAME SUPPORT
-10	1	RB 92700-10321-041-M-10	FRAME TUBE
-11	4	RB 92700-10321-041-M-11	TOP PULLEY MOUNT
-12	2	RB 92700-10321-041-M-12	SIDE PULLEY MOUNT
43	2	McMaster#98381A552 OR EQUIV.	STEEL DOWEL PIN 1/4" DIA. X 2-1/2" LG.
44	2	McMaster#98381A714 OR EQUIV.	STEEL DOWEL PIN 1/2" DIA. X 1-1/4" LG.



RB 92700-10321-041-M-2 FRAME WELDMENT

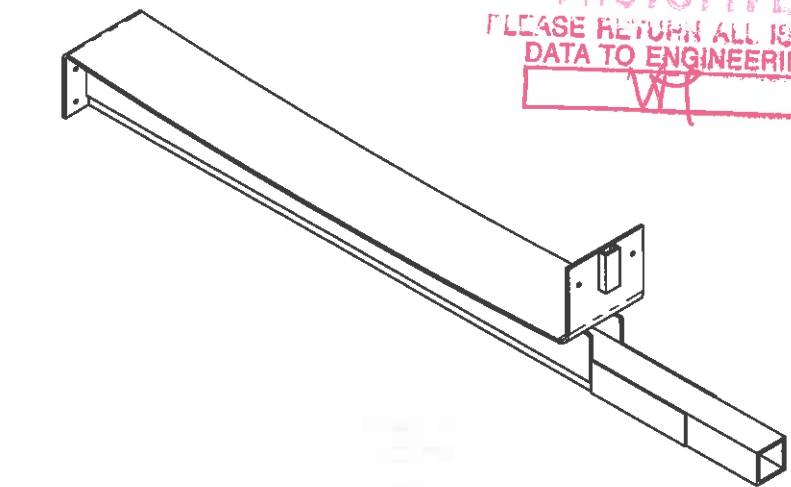
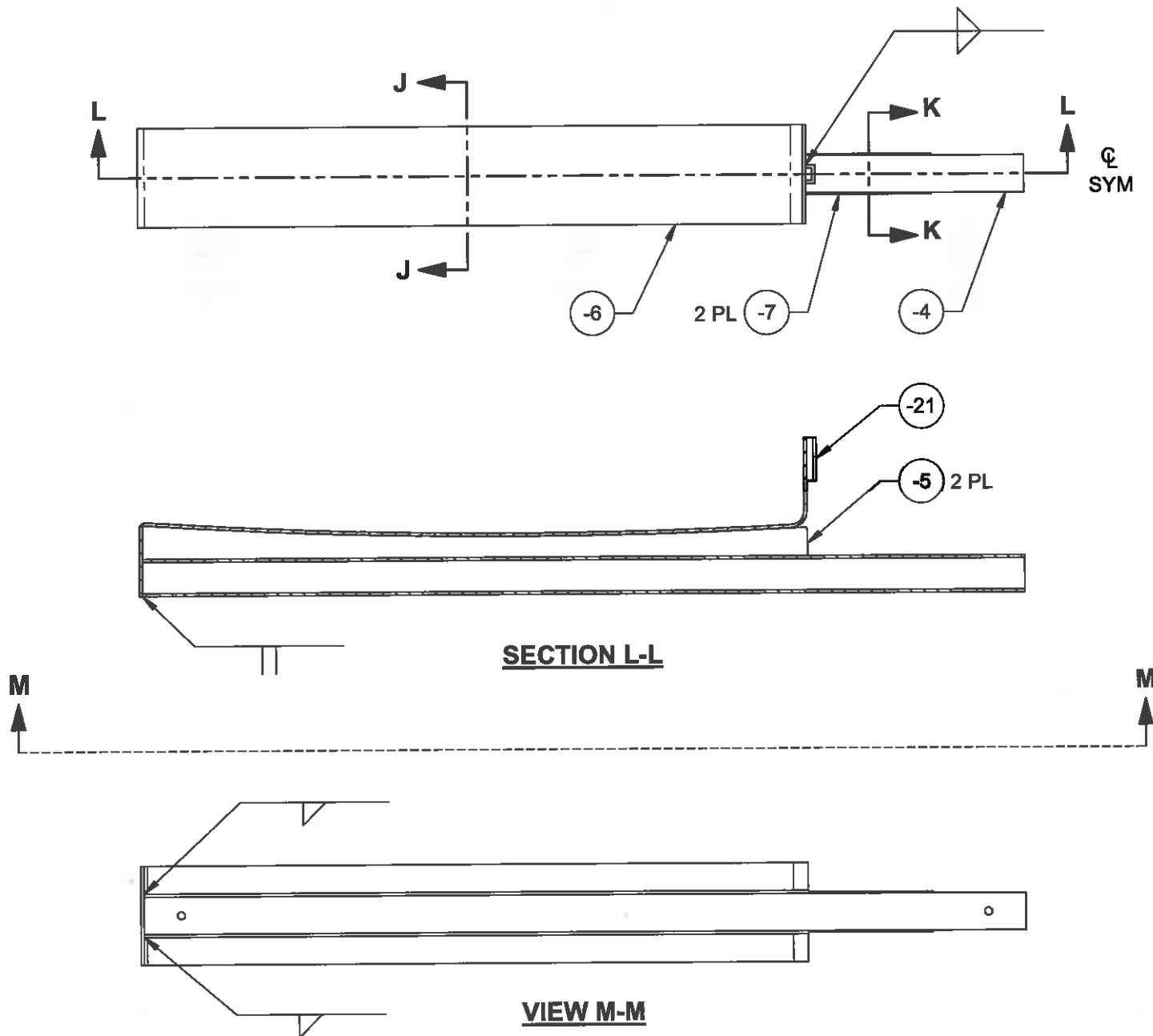
- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: POWDERCOAT RED QSI 005 OR MIL-PRF-24712
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL WELD SPLATTERS
  - 7) IDENTIFICATION: N/A
  - 8) ASSEMBLE AS SHOWN
  - 9) MASK ALL HOLES PRIOR TO POWDERCOAT

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 5 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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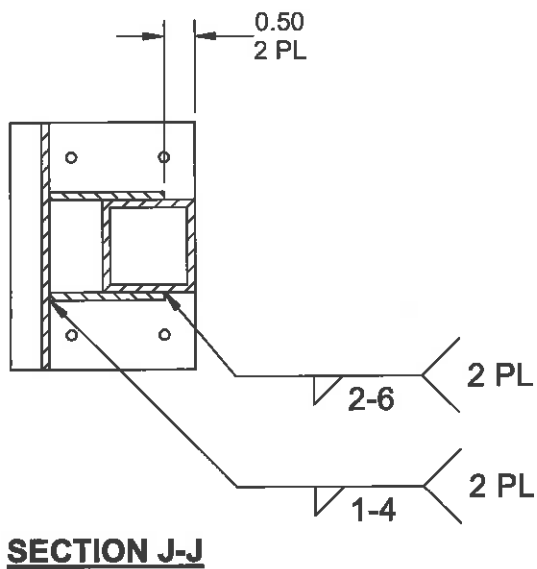




ITEM #	QTY	PART #	PART TITLE
-4	1	RB 92700-10321-041-M-4	BOTTOM CLAMP TUBE
-5	2	RB 92700-10321-041-M-5	BOTTOM CLAMP SUPPORT
-6	1	RB 92700-10321-041-M-6	BOTTOM CLAMP PROFILE
-7	2	RB 92700-10321-041-M-7	SPACER
-21	1	RB 92700-10321-041-M-21	TORSION SPRING HOLDER



RB 92700-10321-041-M-3 BOTTOM CLAMP WELDMENT



- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL WELD SPLATTERS
  - 7) IDENTIFICATION: N/A
  - 8) ASSEMBLE AS SHOWN

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 7 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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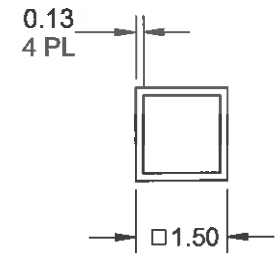
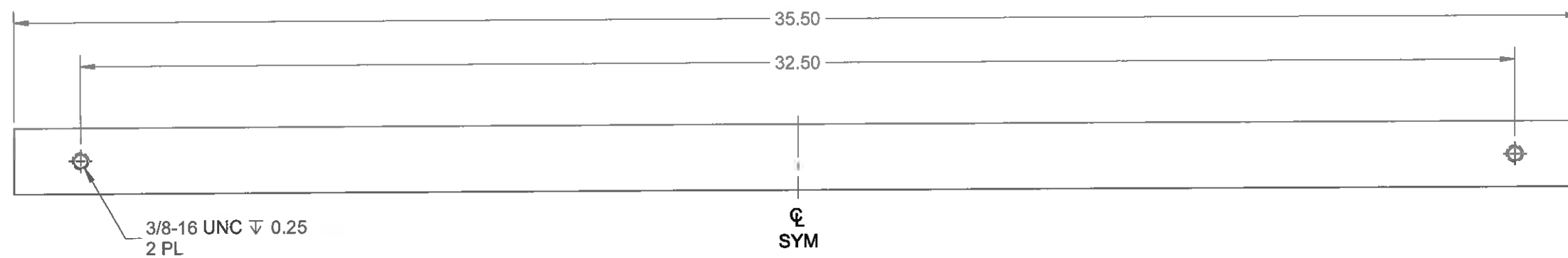
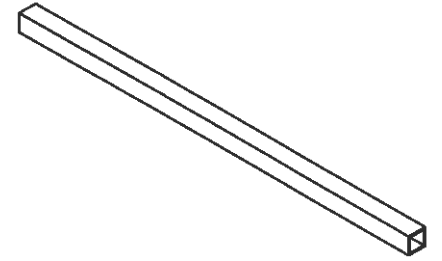
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PROTOTYPE  
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**RB 92700-10321-041-M-4 BOTTOM CLAMP TUBE**

**NOTES:**

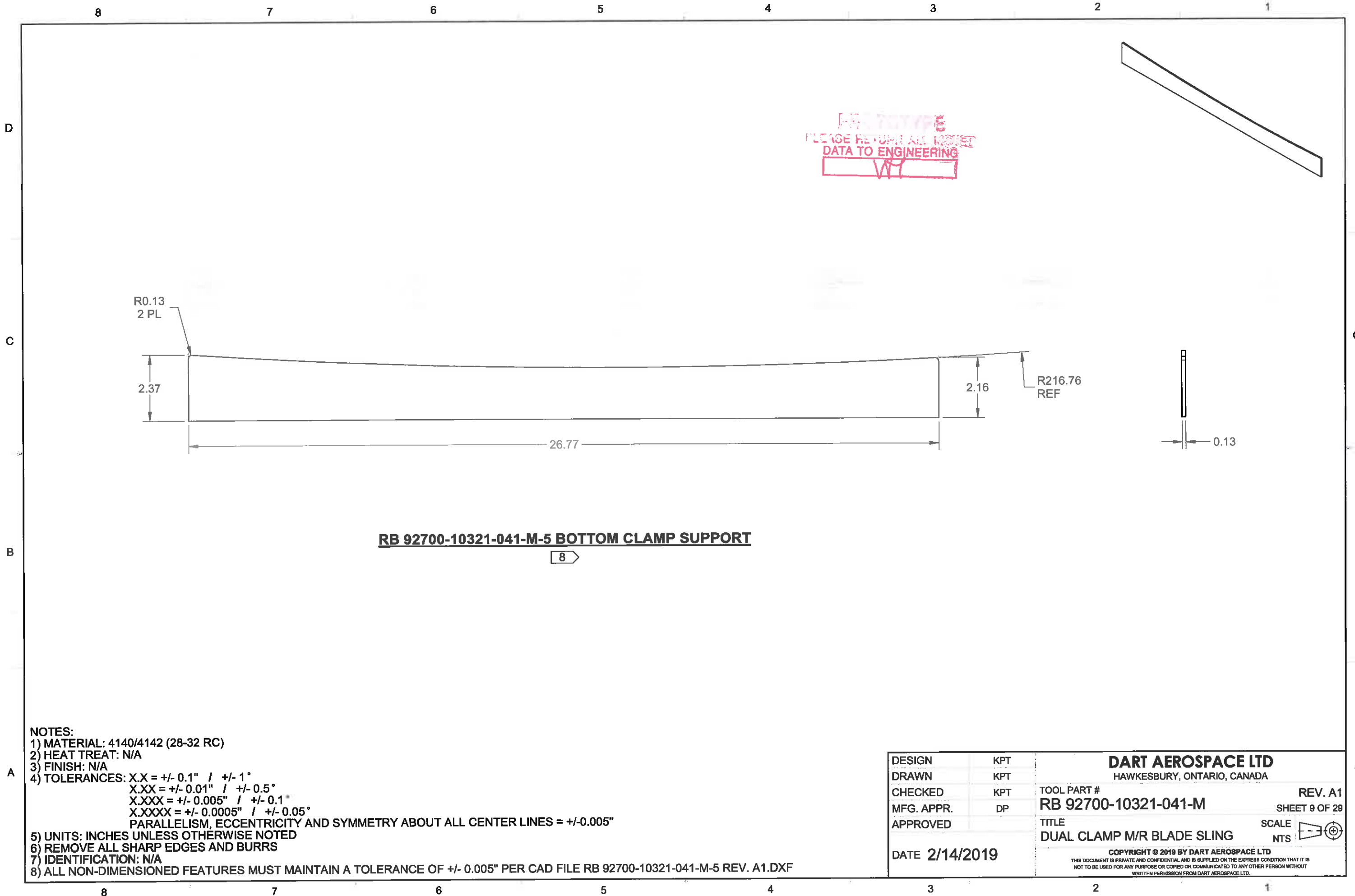
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 8 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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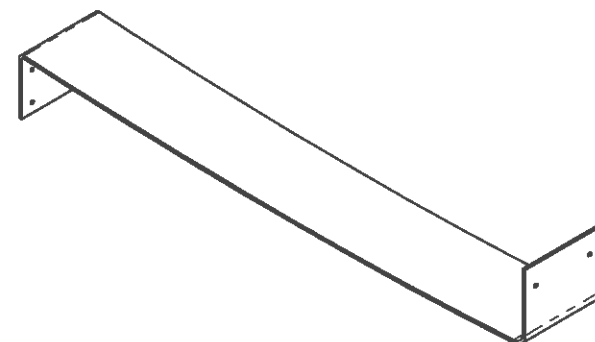
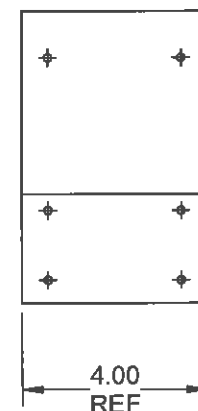
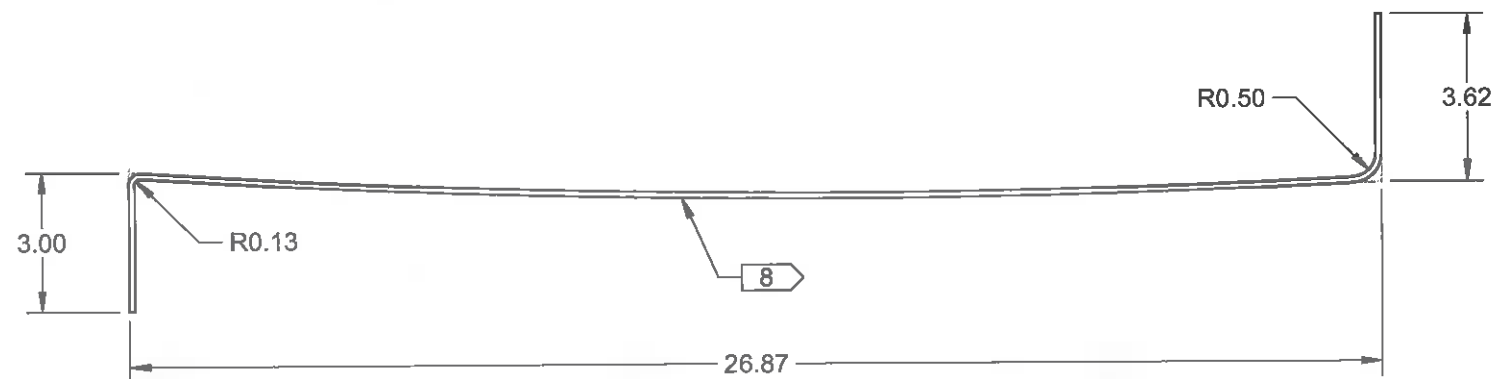




**RB 92700-10321-041-M-5 BOTTOM CLAMP SUPPORT**

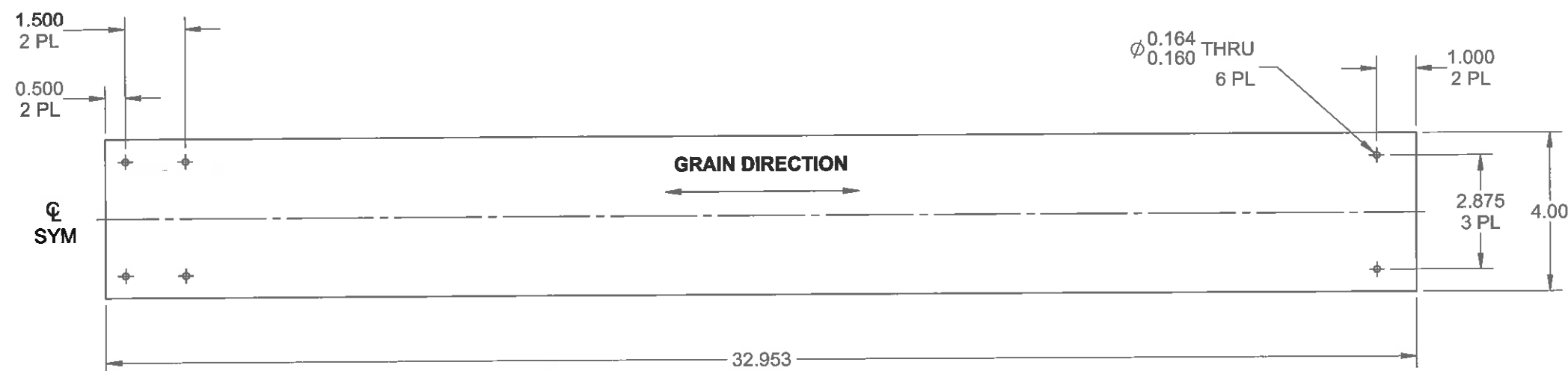
- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: N/A
  - 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB 92700-10321-041-M-5 REV. A1.DXF

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 9 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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**RB 92700-10321-041-M-6 BOTTOM CLAMP PROFILE**

PROTOTYPE  
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**FLAT PATTERN**

**NOTES:**

1) MATERIAL: A36/1018/1020/1025 HR

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°


PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

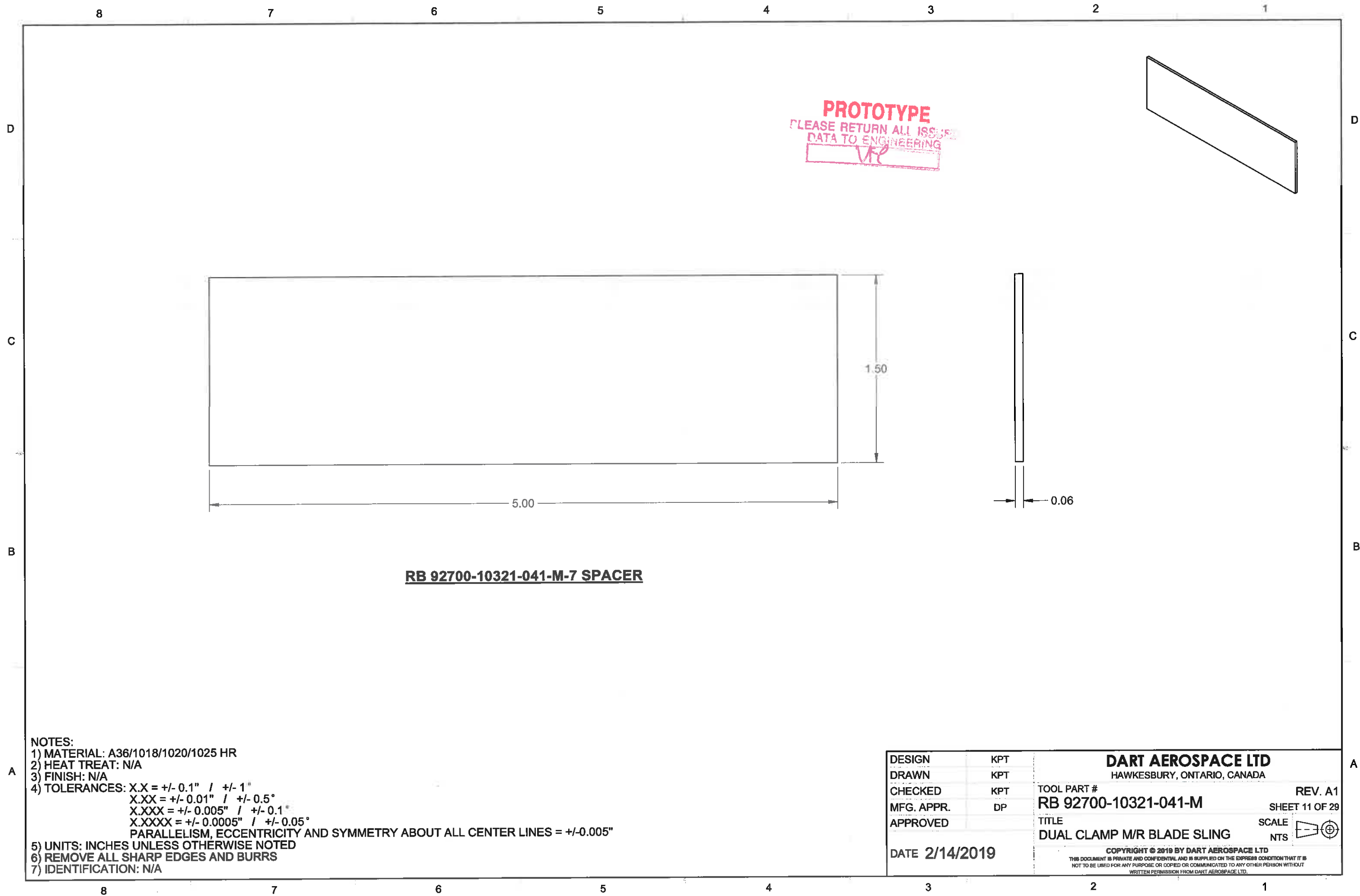
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

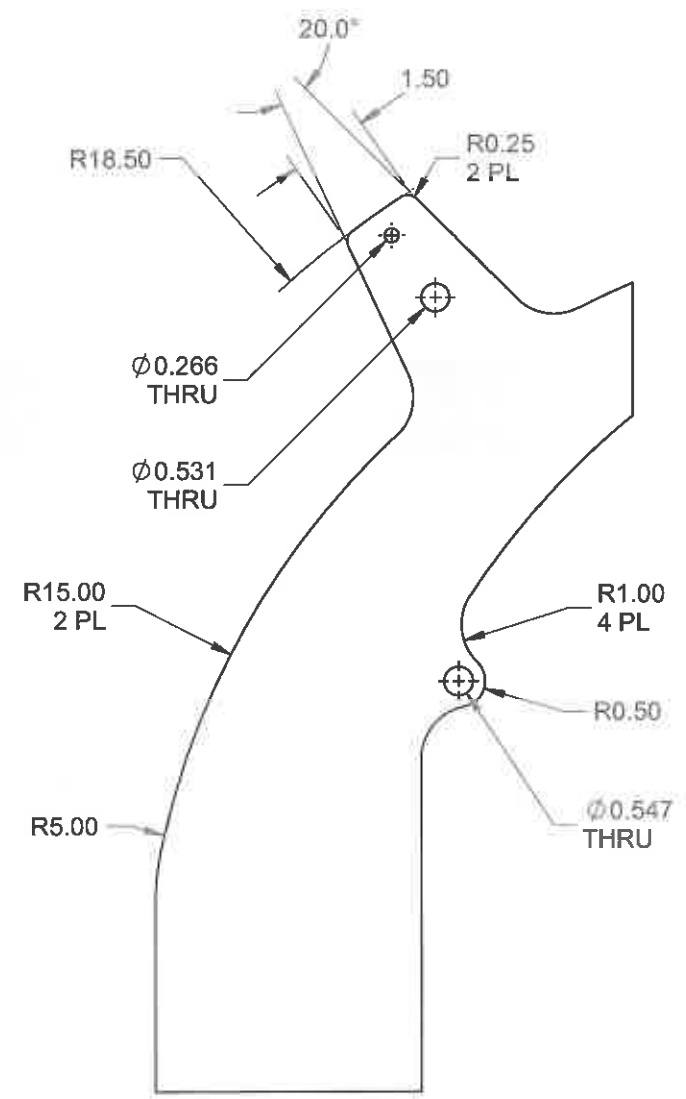
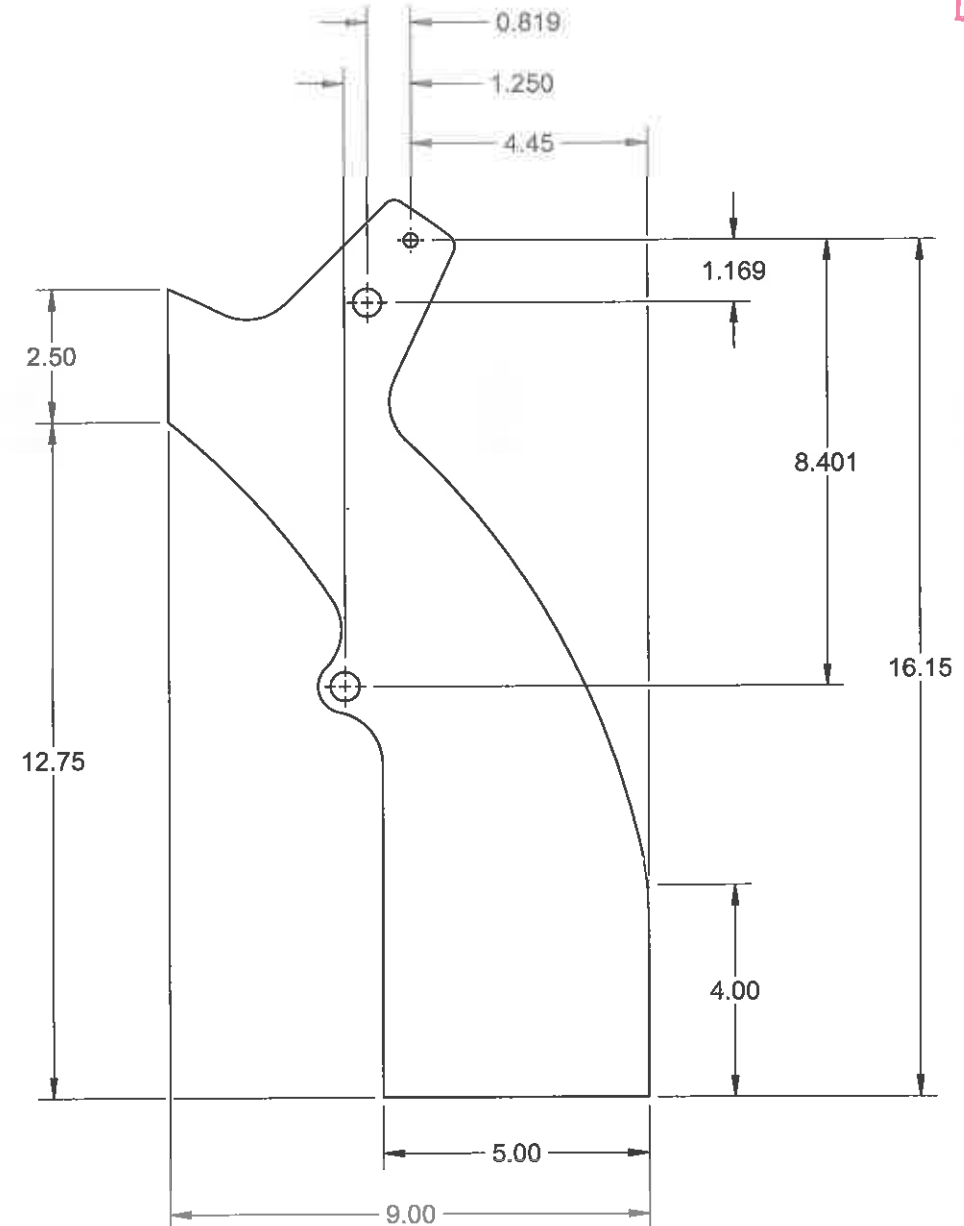
7) IDENTIFICATION: N/A

8) BEND ACCORDING TO PROFILE OF ITEM -5 AT ASSEMBLY

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 10 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS 
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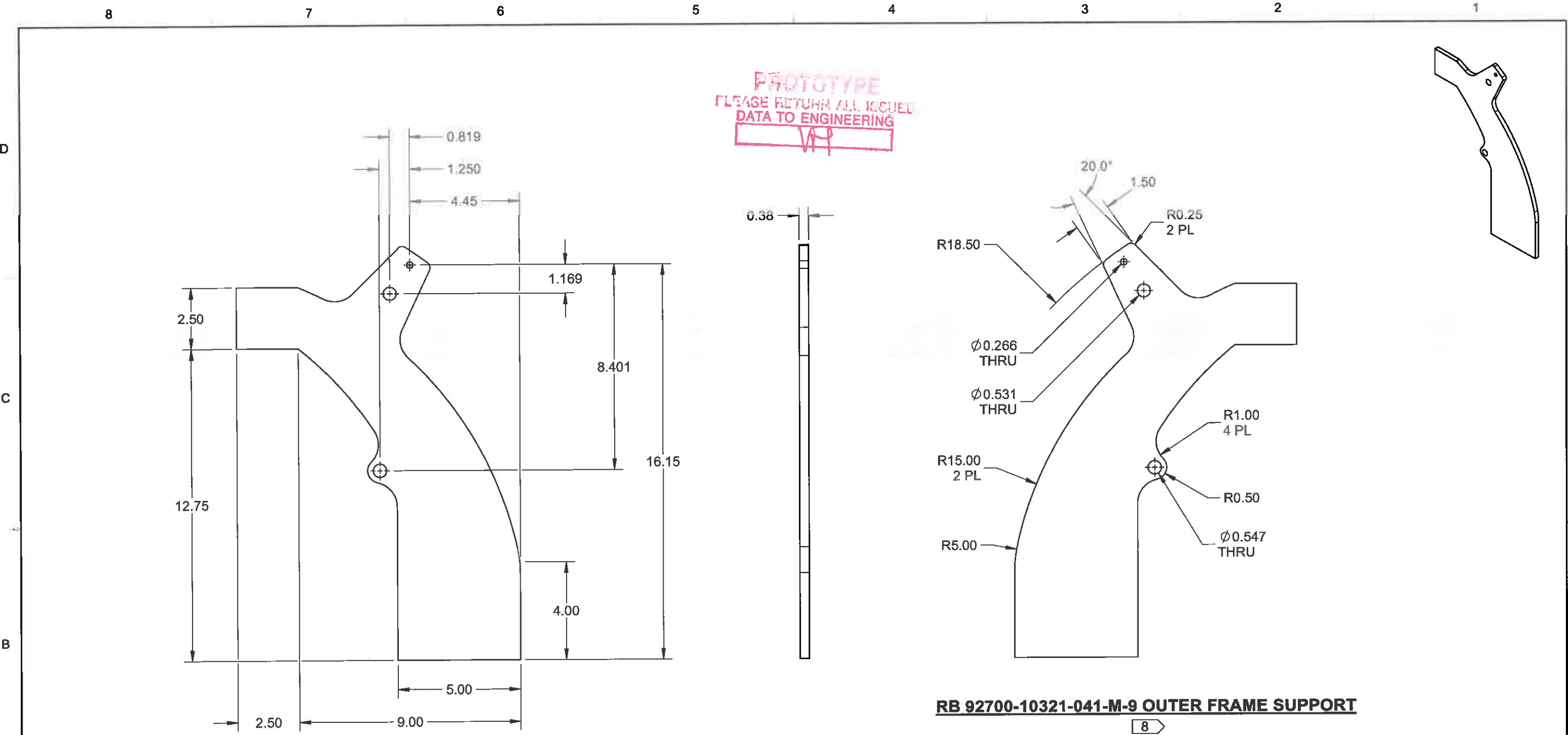
PROTOTYPE  
PLEASE RETURN ALL ISSUE  
DATA TO ENGINEERING



RB 92700-10321-041-M-8 INNER FRAME SUPPORT

NOTES:  
1) MATERIAL: 4140/4142 (28-32 RC)  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL SHARP EDGES AND BURRS  
7) IDENTIFICATION: N/A  
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB 92700-10321-041-M-8 REV. A1.DXF

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 12 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
DATE 2/14/2019		COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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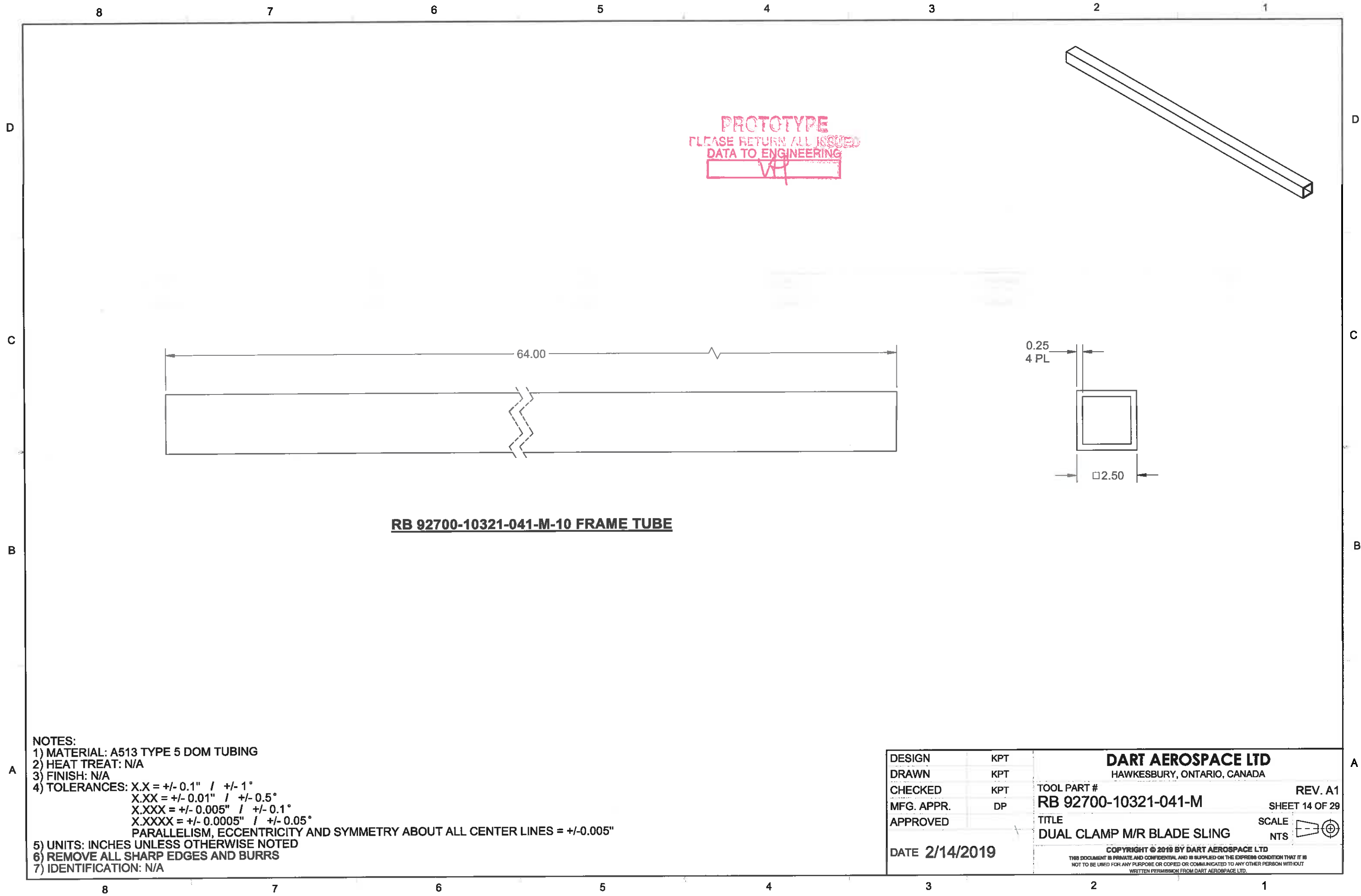


**RB 92700-10321-041-M-9 OUTER FRAME SUPPORT**

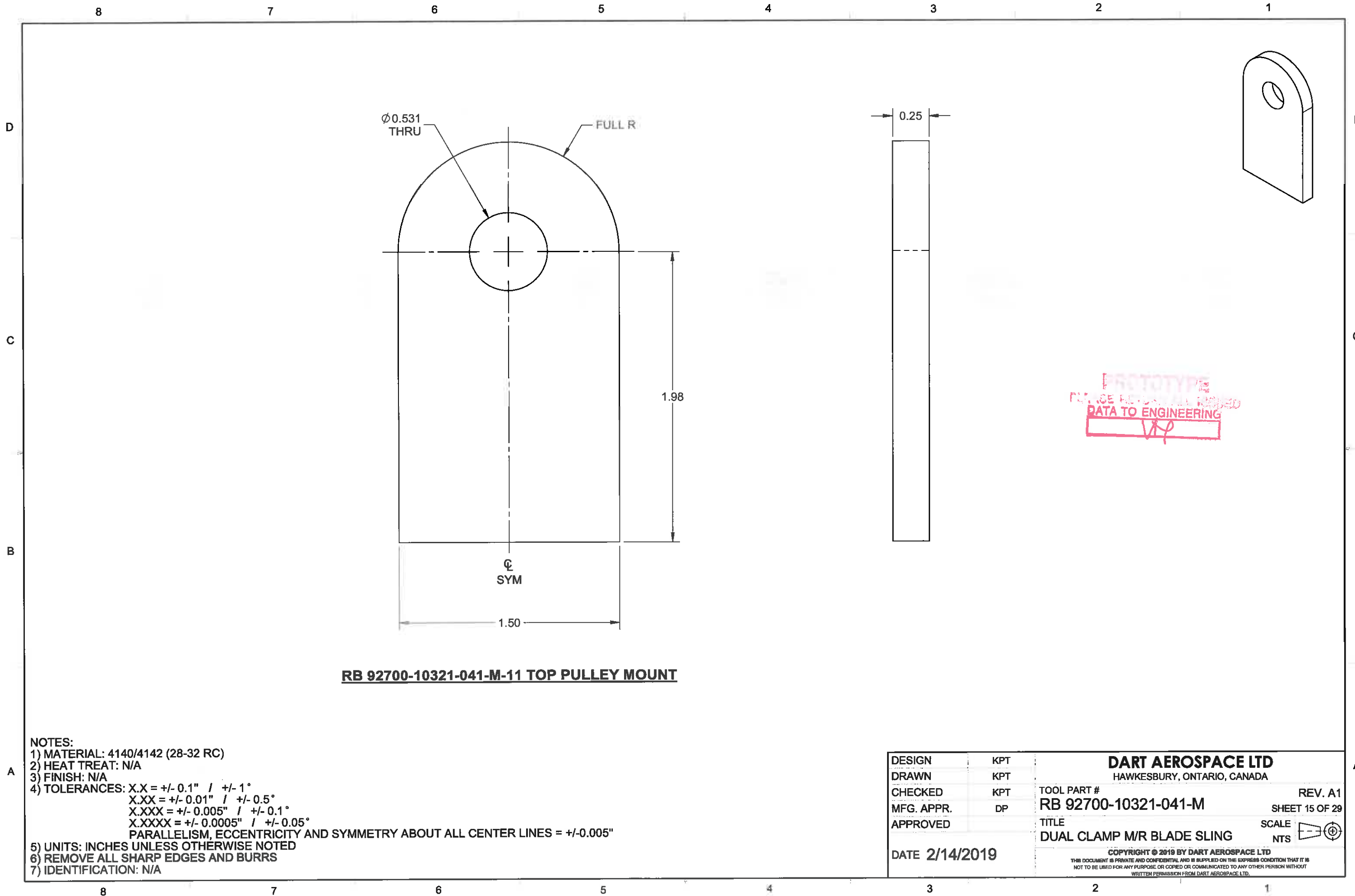
8

- NOTES:**
- 1) MATERIAL: 4140/4142 (28-32 RC)
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: N/A
  - 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB 92700-10321-041-M-9 REV. A1.DXF

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 13 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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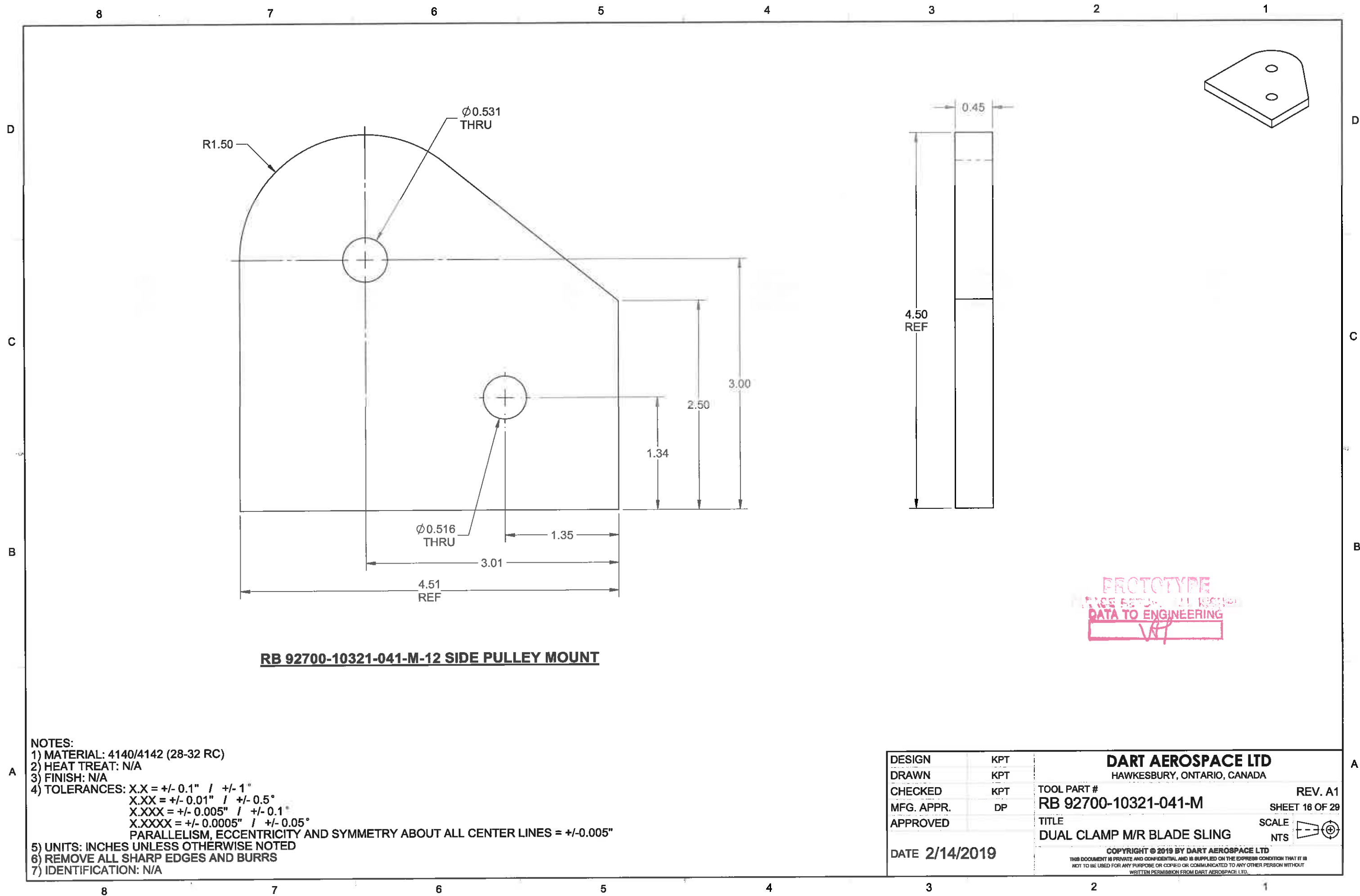




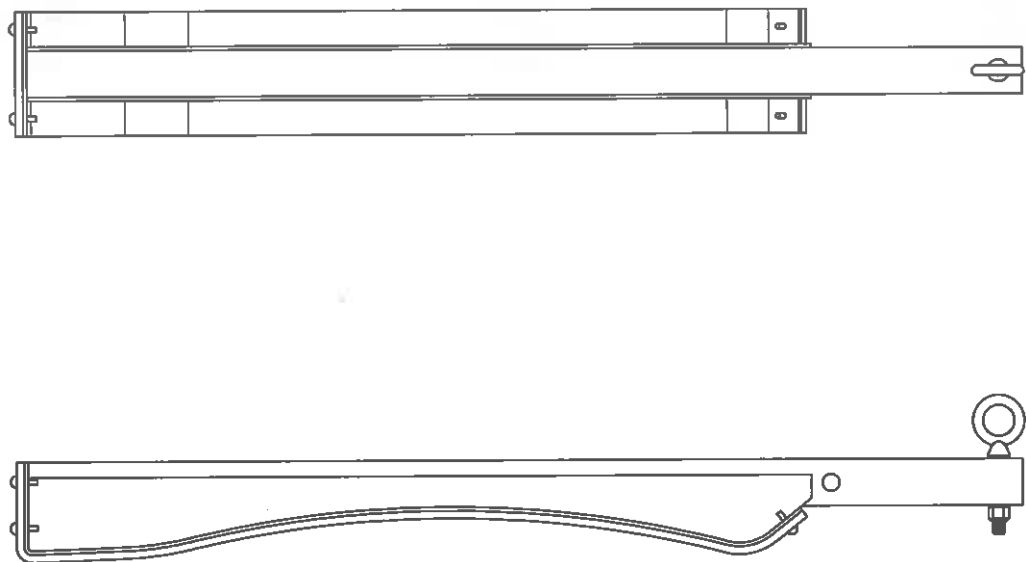
**RB 92700-10321-041-M-11 TOP PULLEY MOUNT**

NOTES:  
1) MATERIAL: 4140/4142 (28-32 RC)  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL SHARP EDGES AND BURRS  
7) IDENTIFICATION: N/A

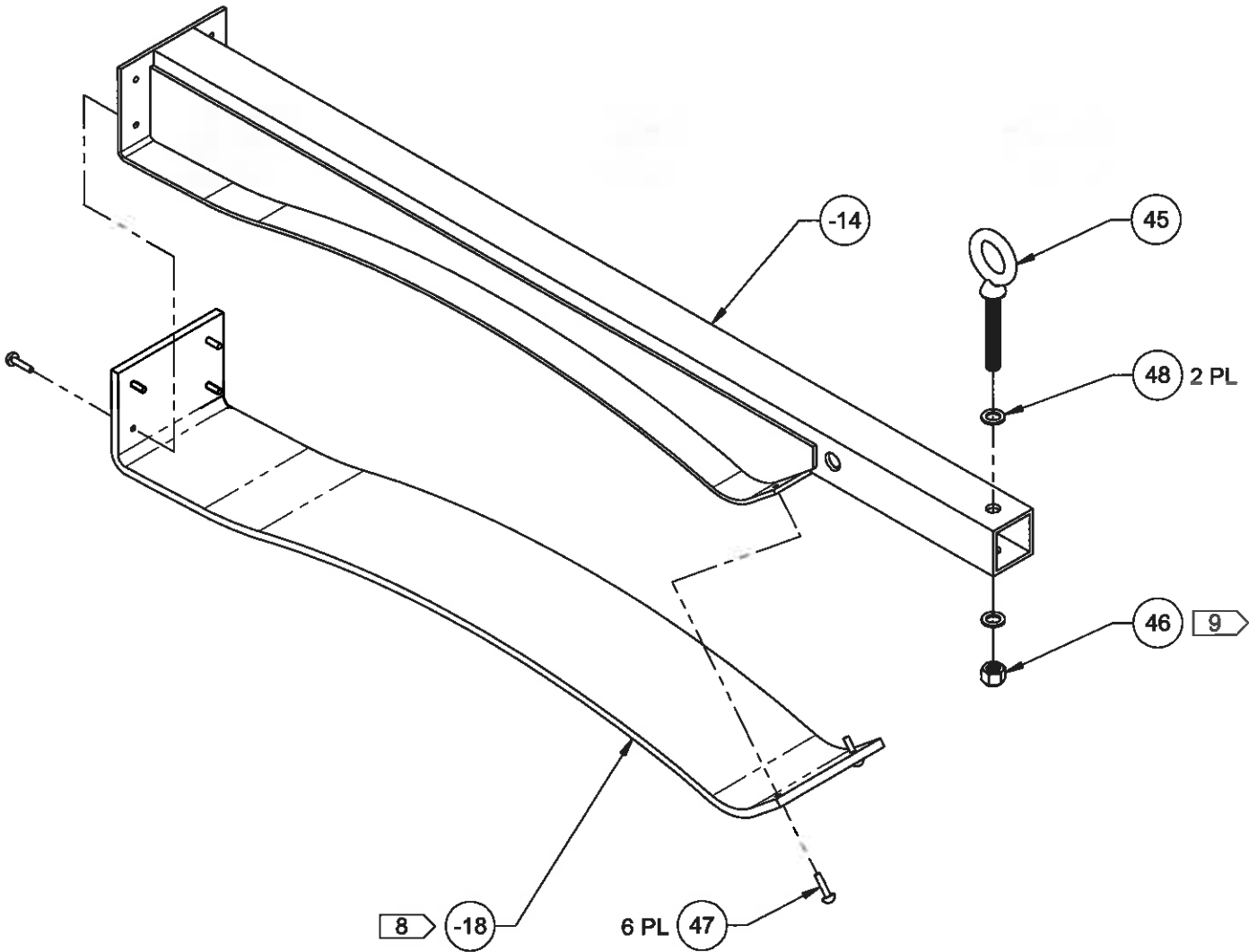
DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 15 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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ITEM #	QTY	PART #	PART TITLE
-14	1	RB 92700-10321-041-M-14	TOP CLAMP WELDMENT
-18	1	RB 92700-10321-041-M-18	TOP CLAMP PROTECTION
45	1	McMaster#3014T142 OR EQUIV.	STEEL EYEBOLT 3/8"-16 X 2-1/2" THREAD LG. X 1" EYE DIA. X 4-1/2" LG.
46	1	McMaster#95615A140 OR EQUIV.	STEEL NYLON INSERT LOCKNUT 3/8"-16 X 29/64" HEIGHT.
47	6	McMaster#97519A042 OR EQUIV.	STEEL BLIND RIVETS 5/32" DIA. X 0.675" LG.
48	2	NAS1149F0663P	WASHER



RB 92700-10321-041-M-13 TOP CLAMP ASSEMBLY



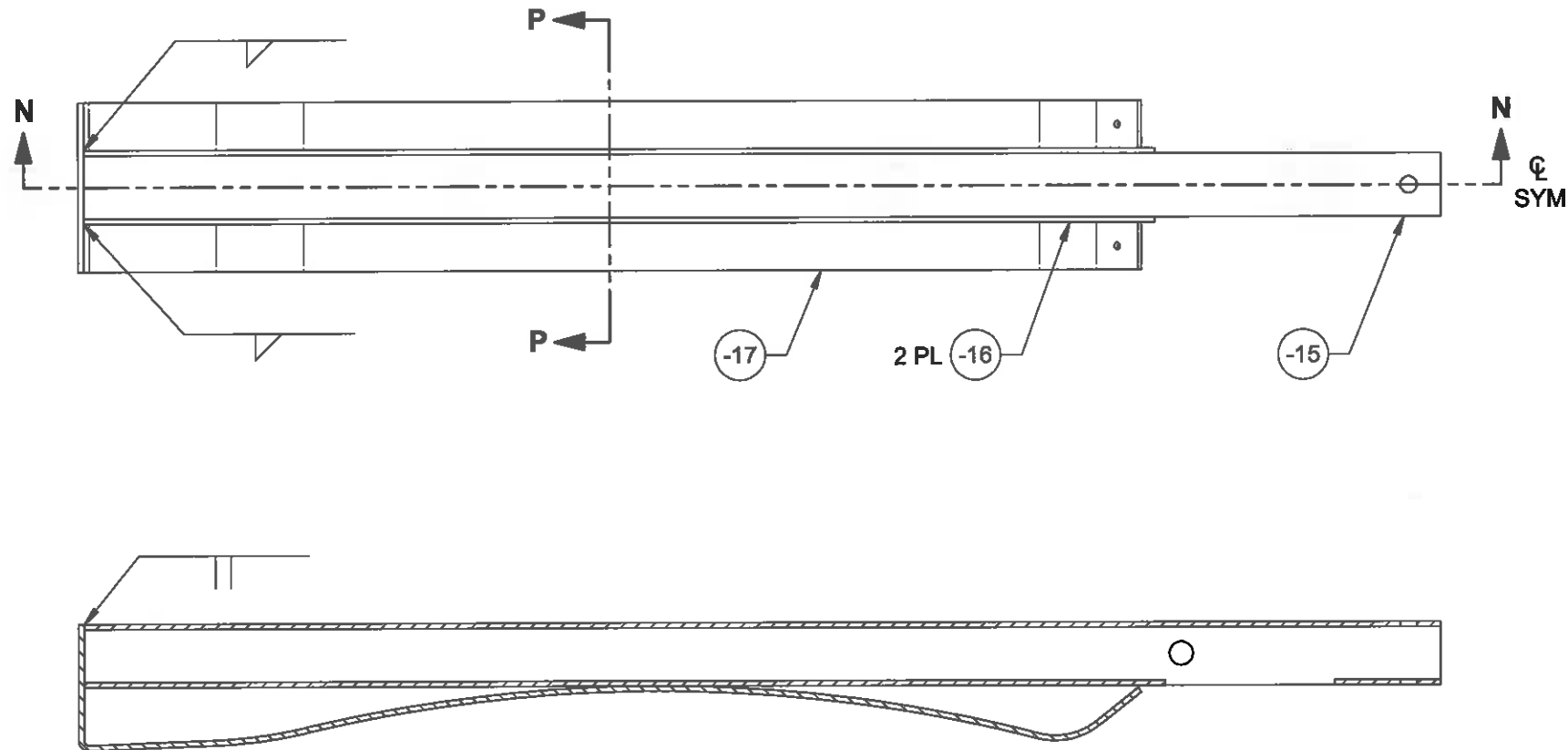
REWORK  
SPACE BETWEEN ALL LEVELS  
DATA TO ENGINEERING  
VLP

- NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) ASSEMBLE AS SHOWN  
8) APPLY 3M 1300L BETWEEN THE SURFACES OF ITEM -18 AND ITEM -14, AND REMOVE EXCESS  
9) TORQUE ITEM 46 TO 13-15 FT-LBS (160-185 IN-LBS)

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 17 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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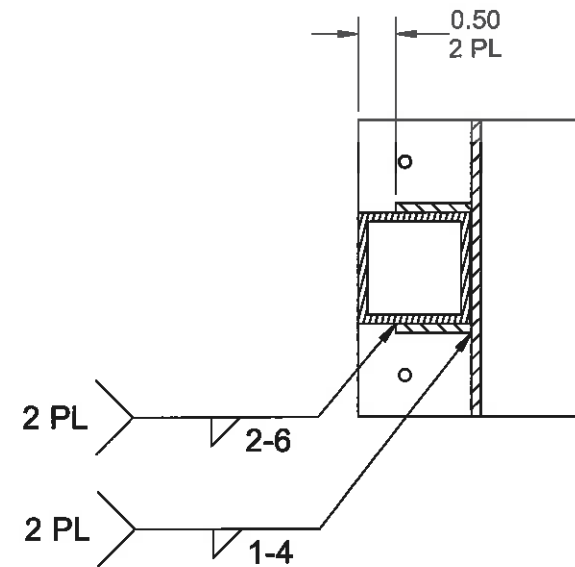
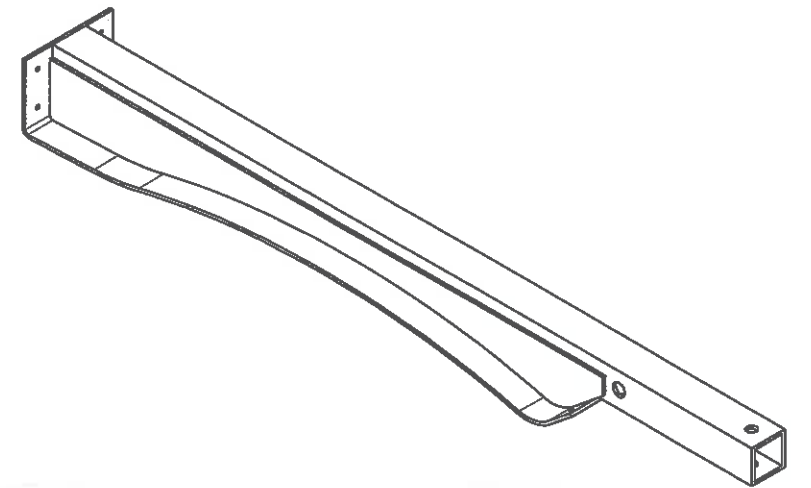
ITEM #	QTY	PART #	PART TITLE
-15	1	RB 92700-10321-041-M-15	TOP CLAMP TUBE
-16	2	RB 92700-10321-041-M-16	TOP CLAMP SUPPORT
-17	1	RB 92700-10321-041-M-17	TOP CLAMP PROFILE

PROTOTYPE  
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SECTION N-N

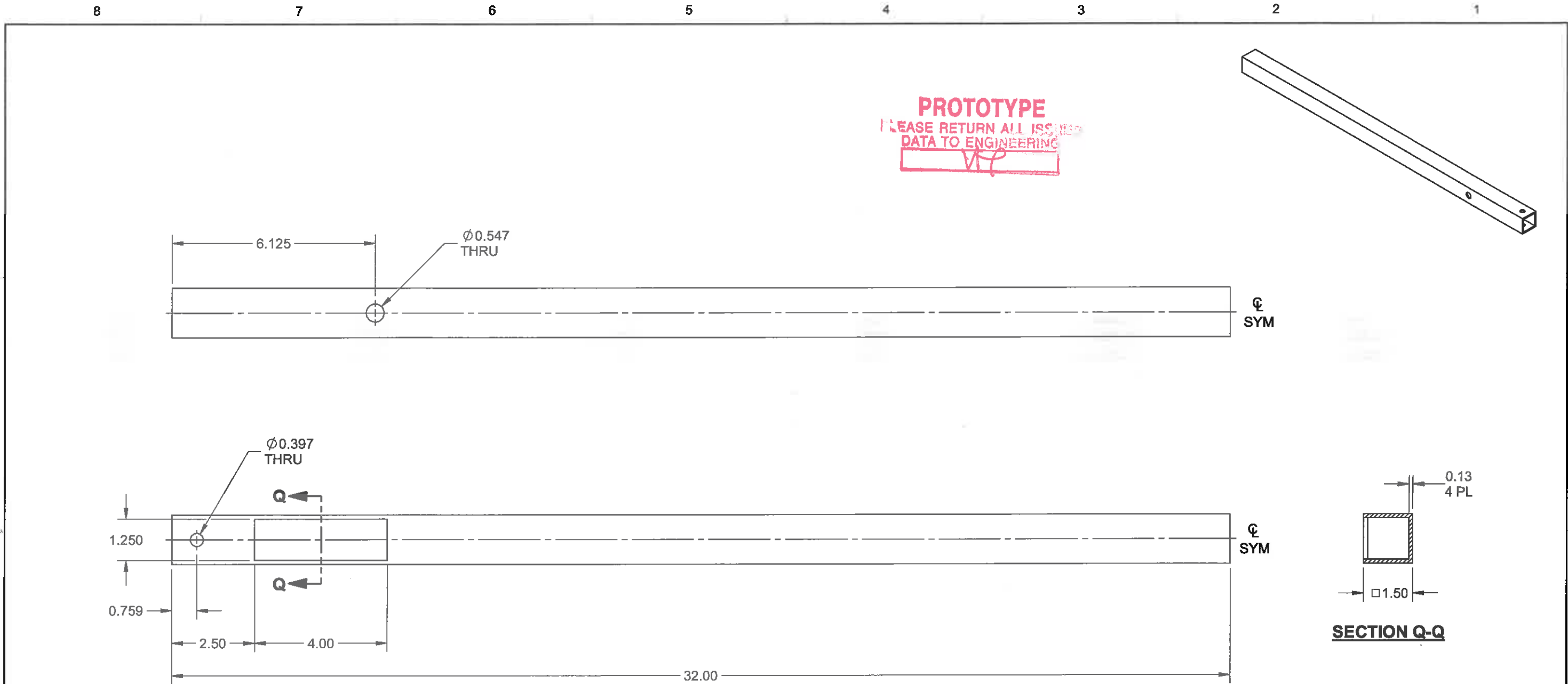
RB 92700-10321-041-M-14 TOP CLAMP WELDMENT



SECTION P-P

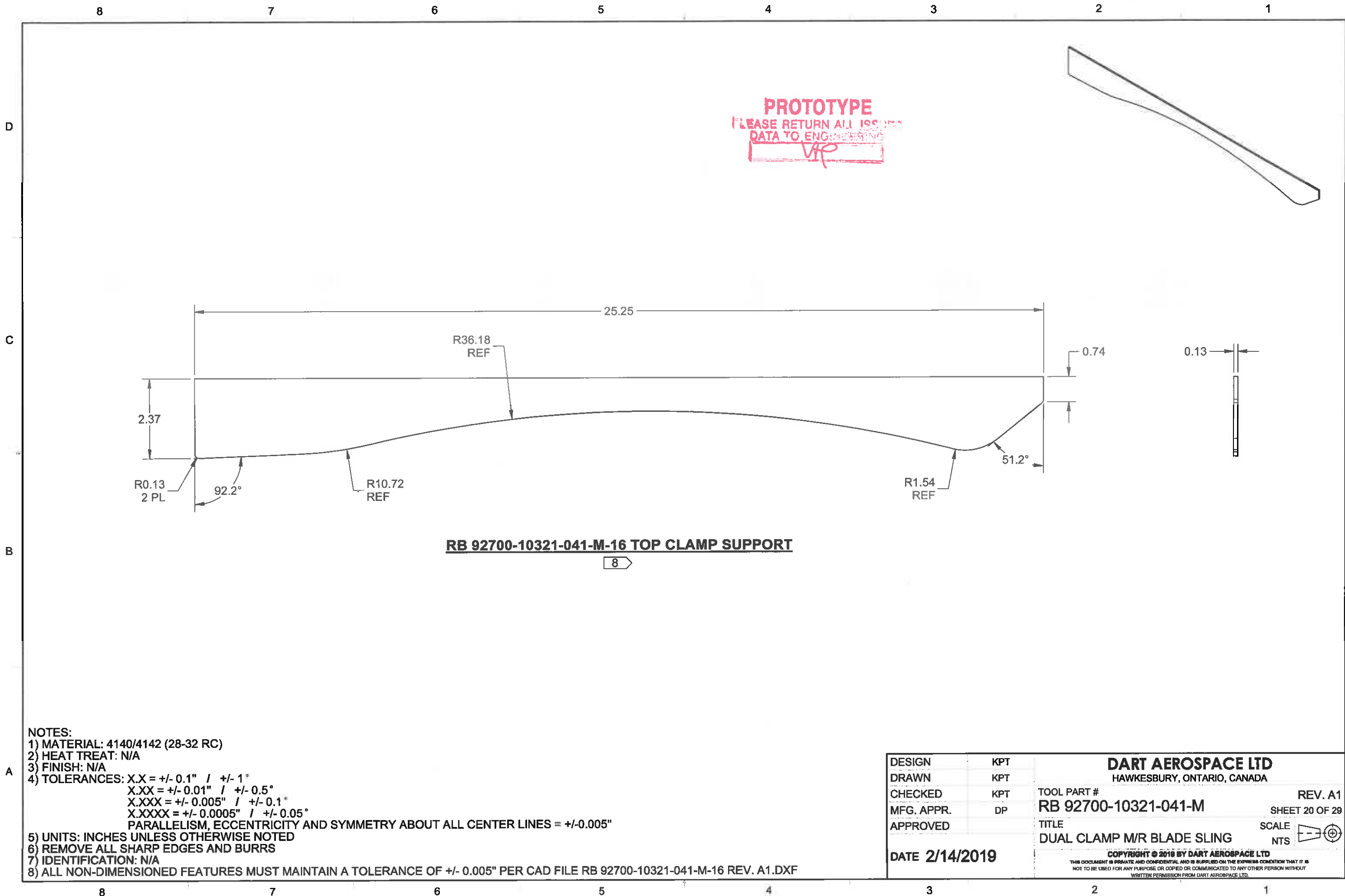
- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: POWDERCOAT RED QSI 005 OR MIL-PRF-24712
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL WELD SPLATTERS
  - 7) IDENTIFICATION: N/A
  - 8) ASSEMBLE AS SHOWN

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 18 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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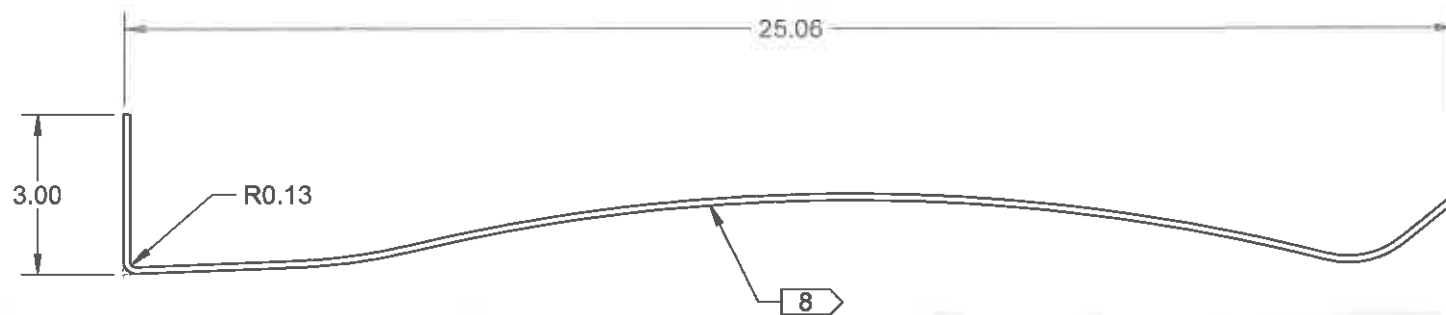
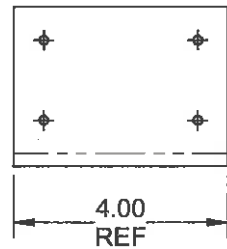


NOTES:  
1) MATERIAL: A513 TYPE 5 DOM TUBING  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL SHARP EDGES AND BURRS  
7) IDENTIFICATION: N/A

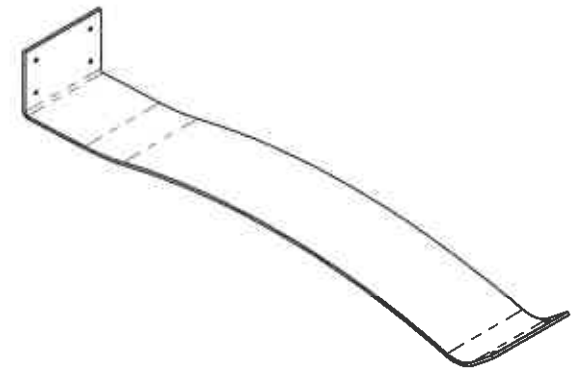
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 19 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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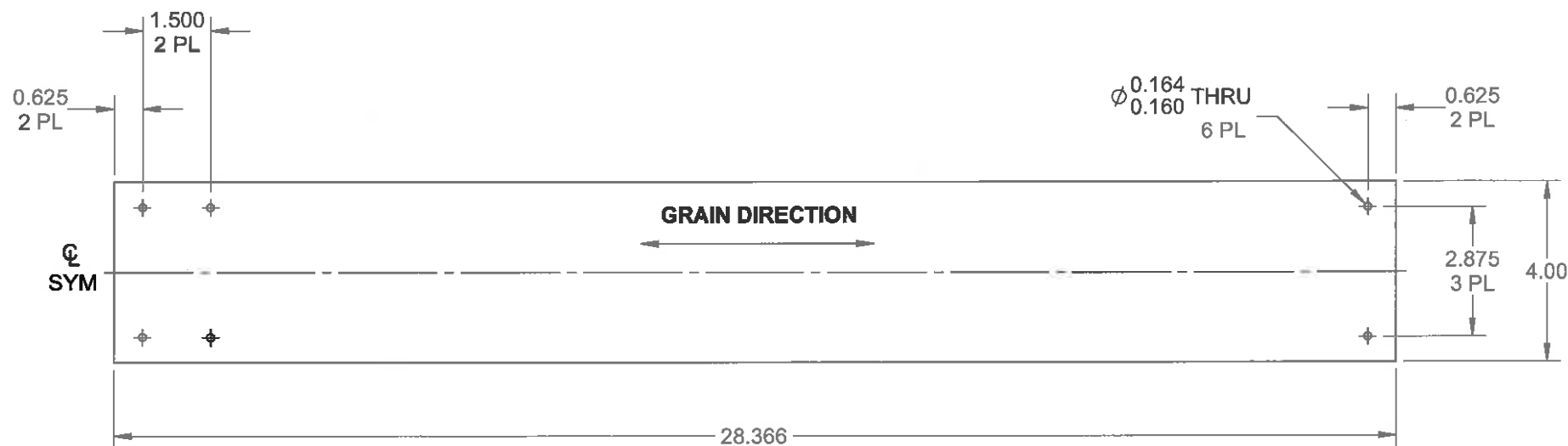




RB 92700-10321-041-M-17 TOP CLAMP PROFILE



PROTOTYPE  
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FLAT PATTERN

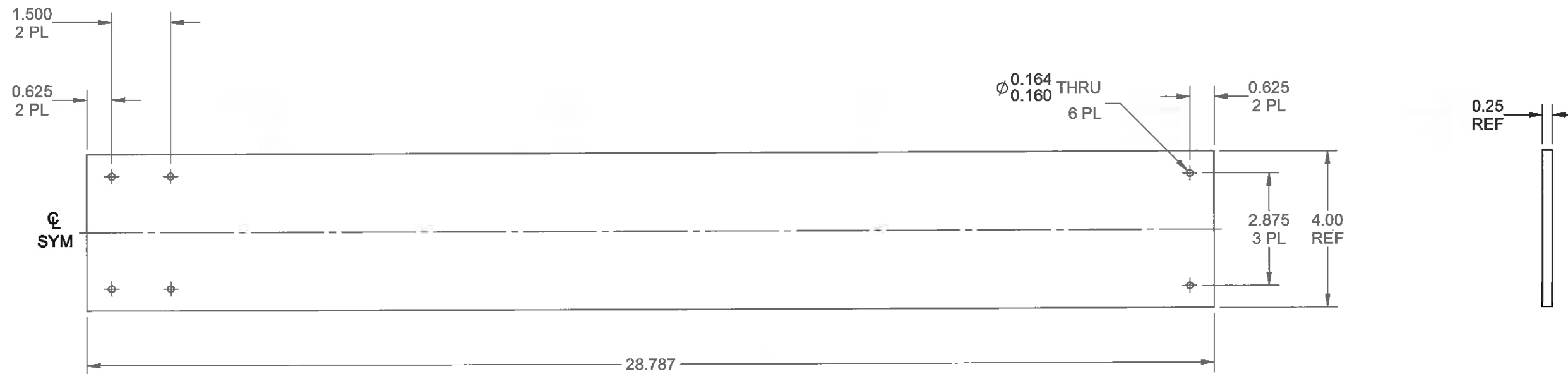
- NOTES:
- 1) MATERIAL: A36/1018/1020/1025 HR
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: N/A
  - 8) BEND ACCORDING TO PROFILE OF ITEM -16 AT ASSEMBLY

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 21 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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**FLAT PATTERN**

**RB 92700-10321-041-M-18 TOP CLAMP PROTECTION**

**PROTOTYPE**  
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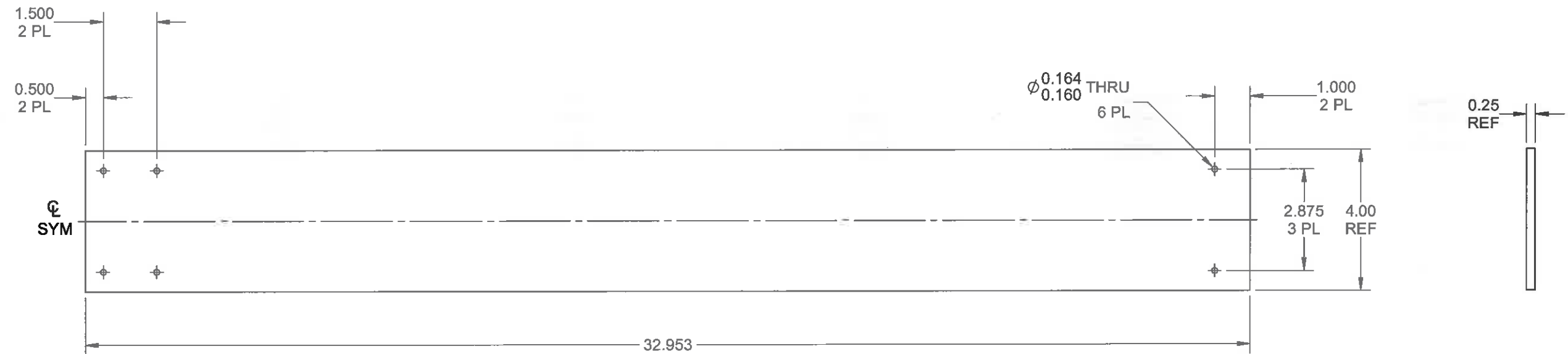
- NOTES:
- 1) MATERIAL: McMaster#3462K16 OR EQUIV.
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 22 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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PROTOTYPE  
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**FLAT PATTERN**

**RB 92700-10321-041-M-19 BOTTOM CLAMP PROTECTION**

**NOTES:**

1) MATERIAL: McMaster#3462K16 OR EQUIV.

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°


X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 23 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS 
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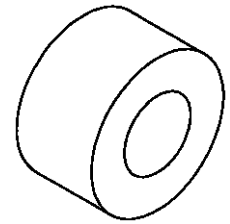
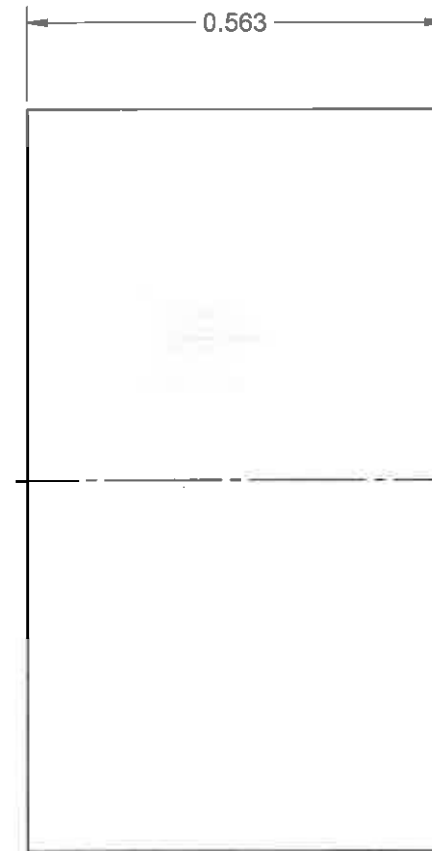
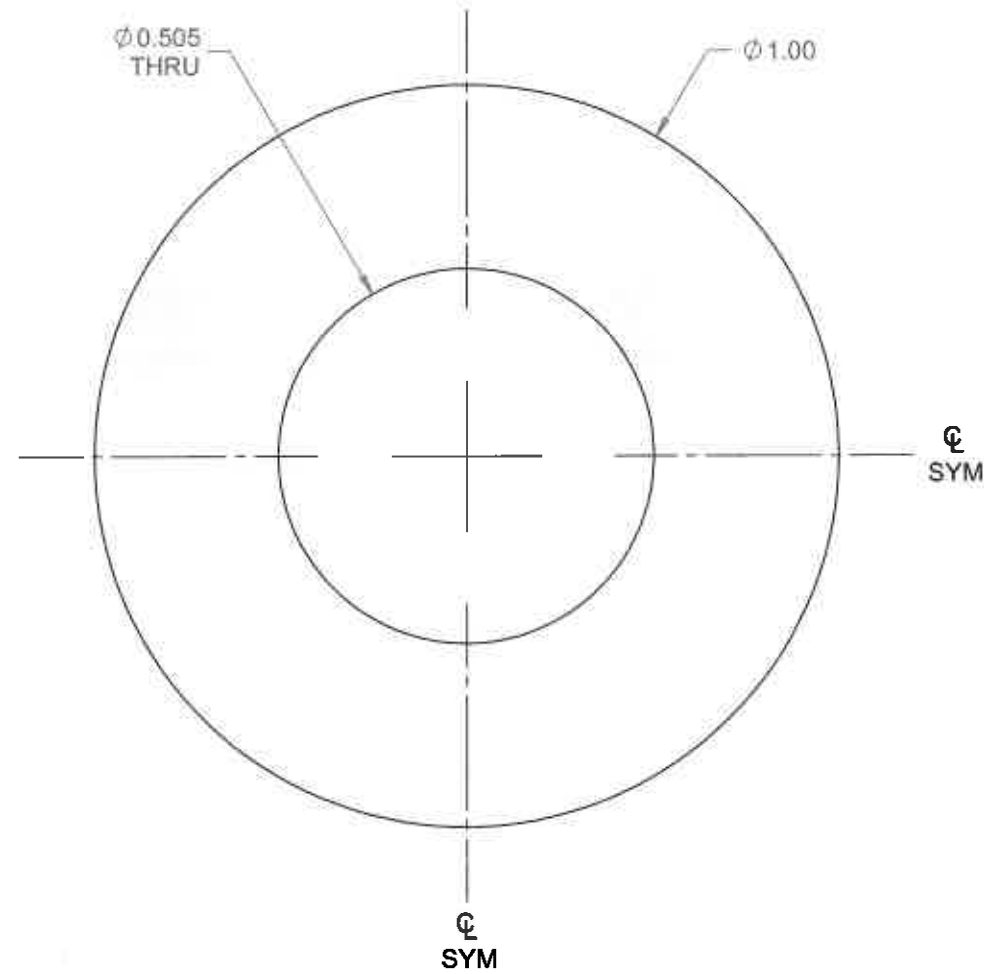
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**RB 92700-10321-041-M-20 PULLEY SPACER**

**PROTOTYPE**  
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**NOTES:**

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 24 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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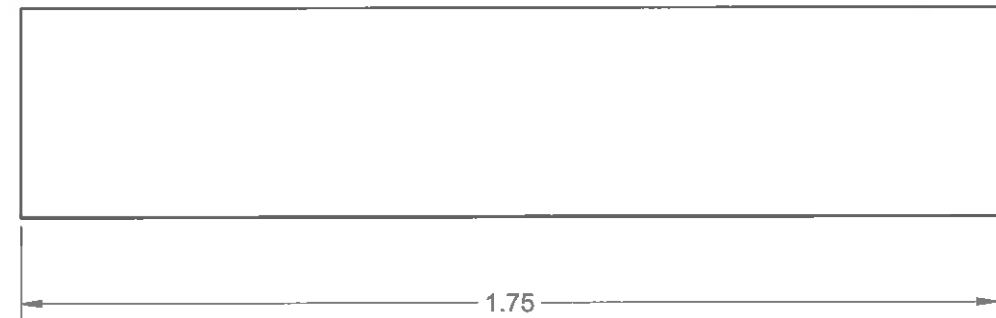
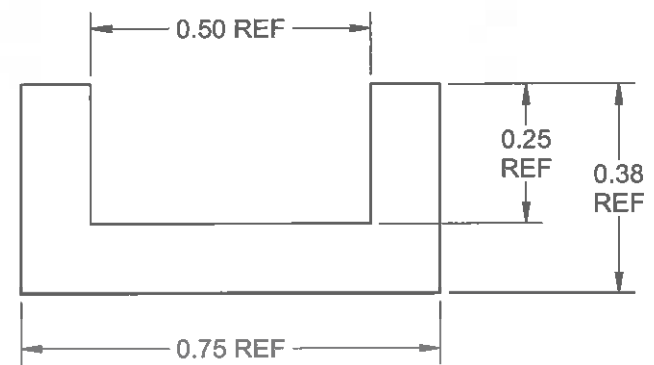
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PROTOTYPE  
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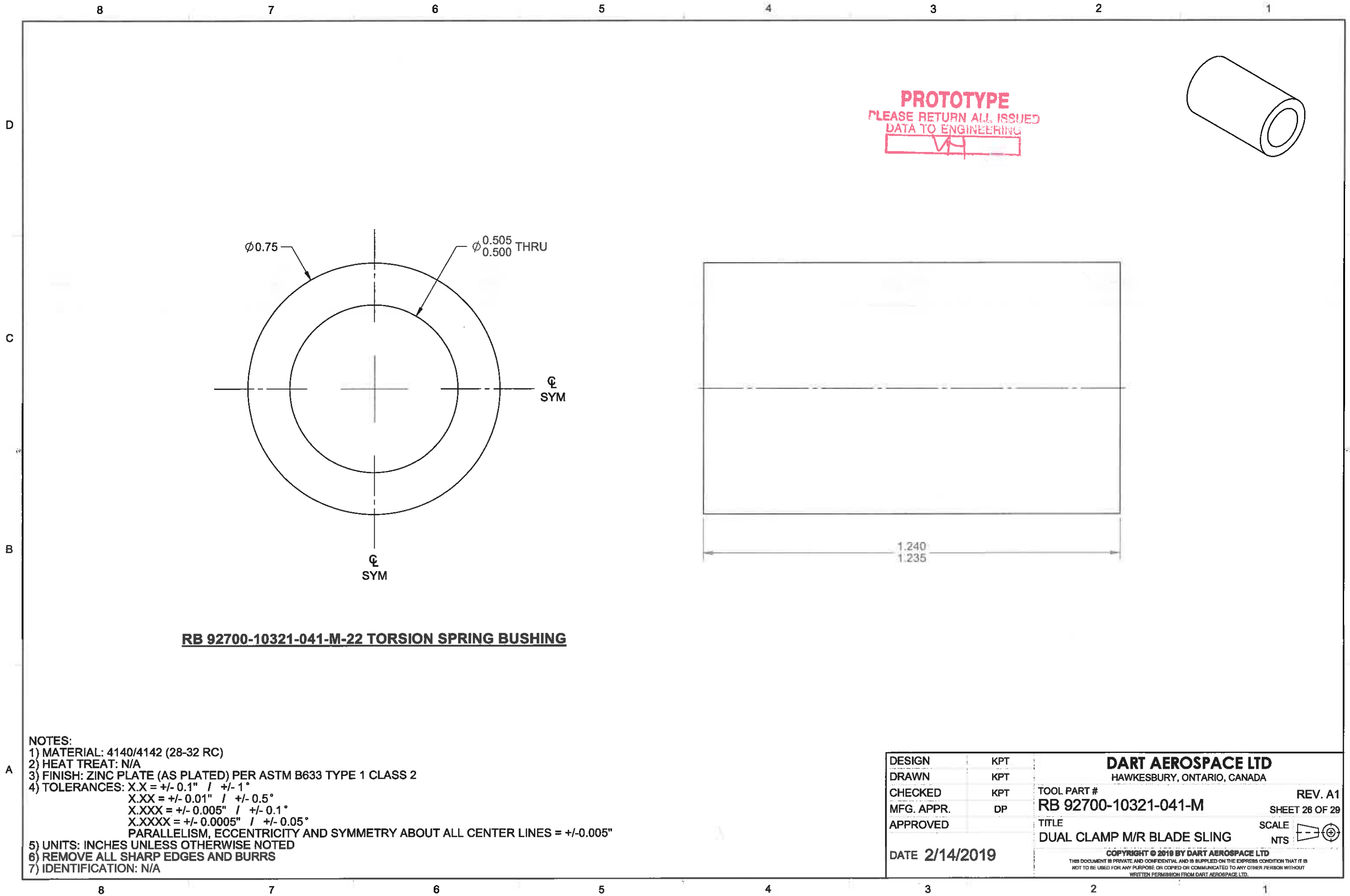


**RB 92700-10321-041-M-21 TORSION SPRING HOLDER**

- NOTES:
- 1) MATERIAL: McMaster#7779T31 OR EQUIV.
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 25 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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**RB 92700-10321-041-M-22 TORSION SPRING BUSHING**

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
  - 2) HEAT TREAT: N/A
  - 3) FINISH: ZINC PLATE (AS PLATED) PER ASTM B633 TYPE 1 CLASS 2
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 26 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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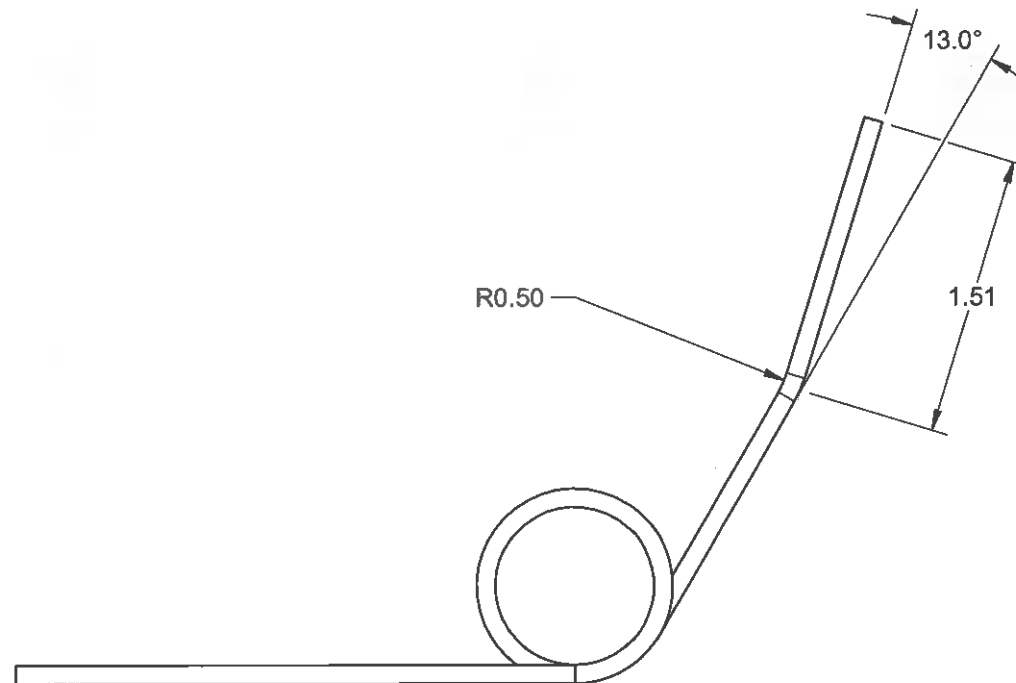
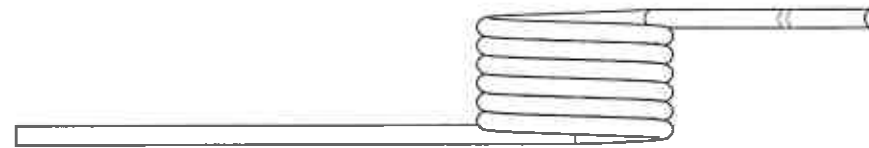
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PROTOTYPE  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
VP



**RB 92700-10321-041-M-23 RIGHT HAND TORSION SPRING**

**NOTES:**

1) MATERIAL: McMaster#9271K911 OR EQUIV.

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 27 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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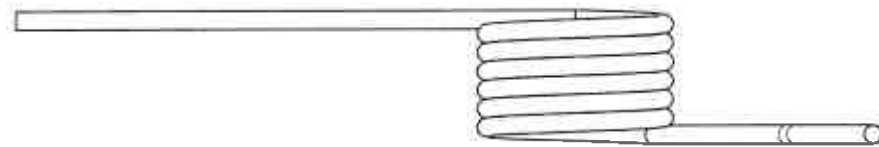
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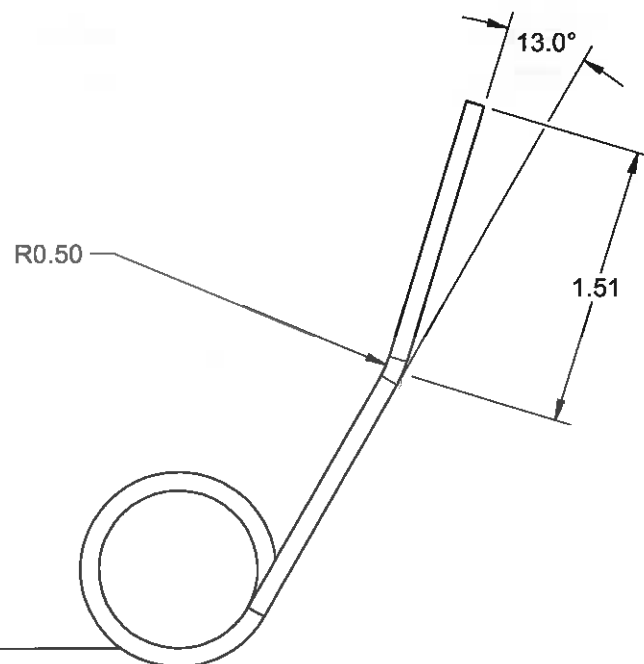
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PROTOTYPE  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
WHP



**RB 92700-10321-041-M-24 LEFT HAND TORSION SPRING**

**NOTES:**

1) MATERIAL: McMaster#9271K926 OR EQUIV.

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 28 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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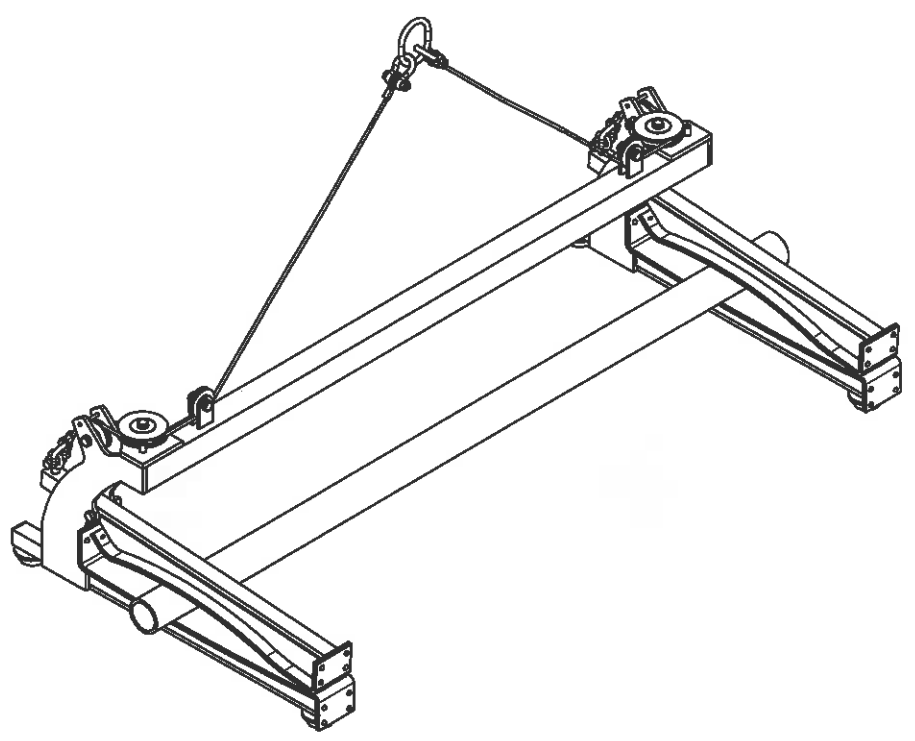
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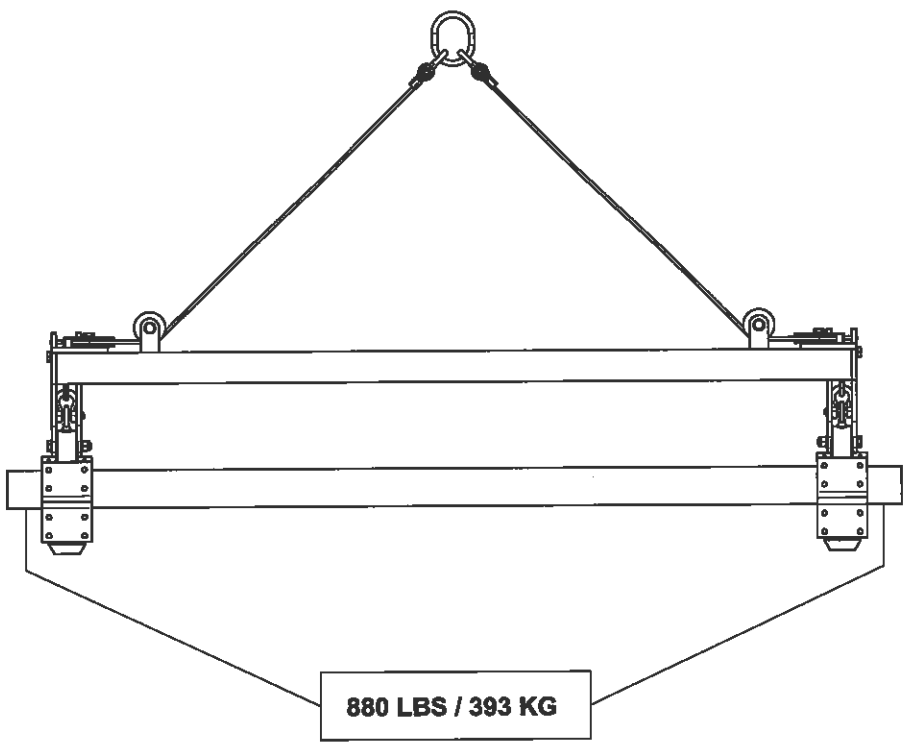
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**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
*VP*



FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE SLING ASSEMBLY ON AN OVERHEAD LIFTING DEVICE. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT OF 880 LBS / 393 KG.
2. LIFT AND MOVE THE SLING ASSEMBLY WITH TEST WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, DISTORTION OR DAMAGED/FRAYED STRAPS.
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, DISTORTIONS OR DAMAGED/FRAYED STRAPS.



INSPECTOR: \_\_\_\_\_  
TESTER: \_\_\_\_\_  
S/N: \_\_\_\_\_  
DATE: \_\_\_\_\_

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	<b>RB 92700-10321-041-M</b>	SHEET 29 OF 29
APPROVED		TITLE	SCALE
		<b>DUAL CLAMP M/R BLADE SLING</b>	NTS
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